

Grizzly *Industrial, Inc.*®

MODEL G0701 19" ULTIMATE BANDSAW OWNER'S MANUAL

(For models manufactured since 03/12)



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OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
#BLTS12076 PRINTED IN TAIWAN



WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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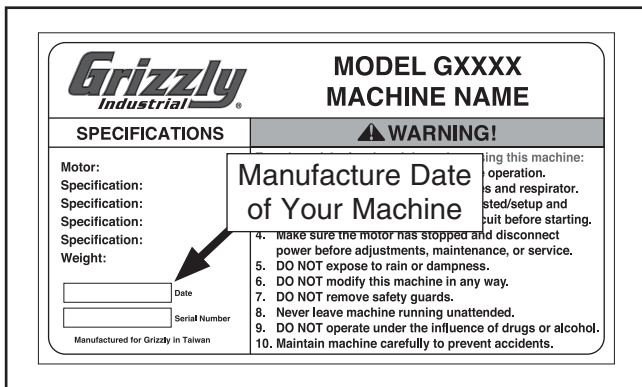
INTRODUCTION

Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes we still make an occasional mistake.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.



For your convenience, we post all available manuals and manual updates for free on our website at www.grizzly.com. Any updates to your model of machine will be reflected in these documents as soon as they are complete.

Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

Grizzly Technical Support
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

Machine Description

The bandsaw is a versatile woodworking tool that is used to perform a wide variety of cuts in wood stock, such as rip cuts, cross cuts, bevel cuts, miter cuts, circular cuts, contour cuts, stacked pattern cuts, etc.

The saw blade is a continuous metal band wrapped around two rotating wheels, which performs the cut as it passes through the workpiece and table. Adjustable blade guide and support bearings keep the blade in position during this operation.

The Model G0701 also features a powered guide post for quick and accurate positioning of the upper guide and support bearings relative to the workpiece.



Identification

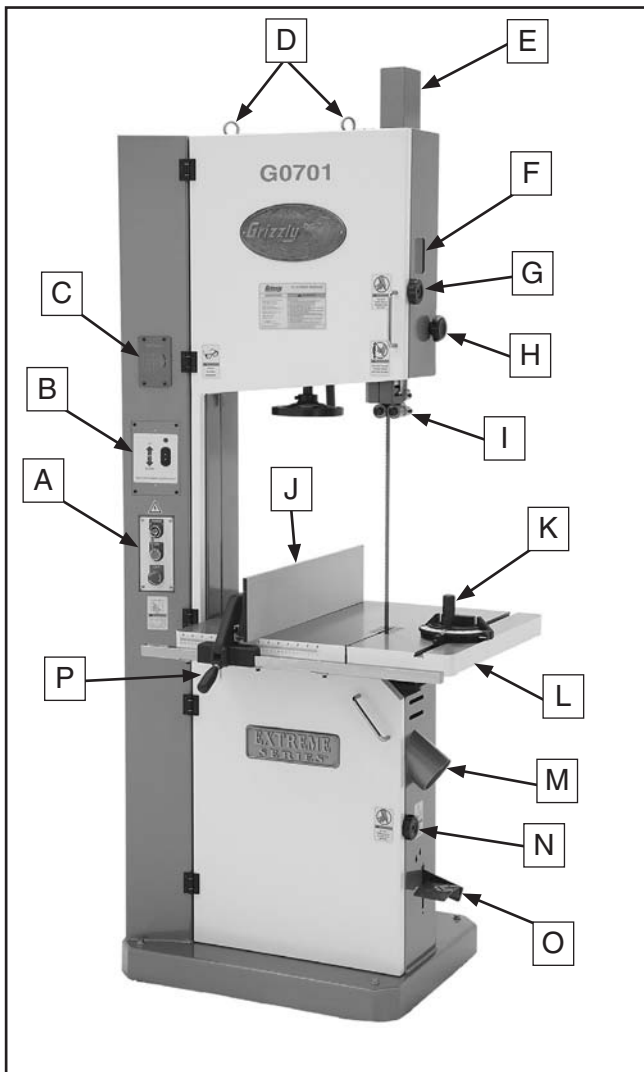


Figure 1. G0701 front view.

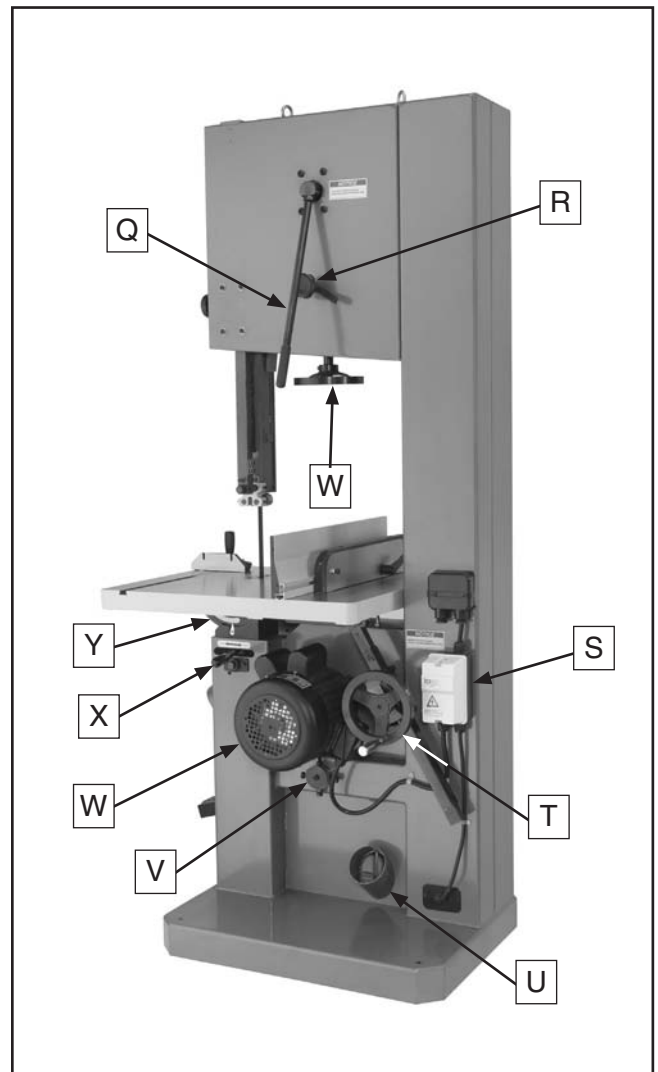


Figure 2. G0701 rear view.

- A.** Key Switch, ON & OFF Buttons
- B.** Guide Post Elevation Control
- C.** Blade Tension Scale
- D.** Lifting Eye Bolts
- E.** Guide Post Top Cap
- F.** Blade Tracking Window
- G.** Upper Wheel Cover Lock Knob
- H.** Guide Post Lock Knob
- I.** Upper Blade Guide Assembly
- J.** Fence w/Re-Saw Attachment
- K.** Miter Gauge
- L.** Table
- M.** 4" Side Dust Port

- N.** Lower Wheel Cover Lock Knob
- O.** Foot Brake
- P.** Fence Lock Lever
- Q.** Blade Tension Quick Release Lever
- R.** Blade Tracking Knob & Lock Lever
- S.** Magnetic Switch
- T.** Table Tilt Handwheel
- U.** 4" Rear Dust Port
- V.** Lower Wheel Adjustment Hub
- W.** Main Motor
- X.** Table Tilt Lock Handle
- Y.** Table Tilt Scale





MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL G0701 19" ULTIMATE BANDSAW

Product Dimensions:

Weight..... 717 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 36-5/8 x 33 x 86-1/2 in.
Footprint (Length x Width)..... 31 x 23-1/2 in.

Shipping Dimensions:

Type..... Wood Crate
Content..... Machine
Weight..... 810 lbs.
Length x Width x Height..... 38 x 26 x 87 in.

Electrical:

Power Requirement..... 230V, Single-Phase, 60 Hz
Minimum Circuit Size..... 30A
Switch..... Magnetic Switch with Thermal Overload Protection
Switch Voltage..... 230V
Cord Gauge..... 12 AWG
Plug Included..... No
Recommended Plug/Outlet Type..... L6-30

Motors:

Main

Type..... TEFC Capacitor Start Induction
Horsepower..... 5 HP
Voltage..... 230V
Phase..... Single
Amps..... 22A
Speed..... 1725 RPM
Cycle..... 60 Hz
Number of Speeds..... 1
Power Transfer Belt Drive
Bearings..... Shielded and Permanently Lubricated

Guide Post

Type..... Universal DC
Horsepower..... 40W
Voltage..... 12V
Amps..... 5A
Speed..... 4300 RPM
Number of Speeds..... 1
Power Transfer Gear Drive
Bearings..... Sealed and Lubricated

Main Specifications:

Operation

Bandsaw Size..... 19 in.
Blade Speeds..... 4975 FPM
Table Tilt..... Left 5, Right 45 deg.



Cutting Capacities

Maximum Cutting Height..... 19-1/2 in.
Max Resaw Height..... 19-1/2 in.
Max Capacity Left of Blade..... 18-3/8 in.

Blade Information

Standard Blade Length..... 166-168 in.
Blade Width Range..... 3/8 - 1-3/8 in.
Upper Blade Guides..... Ball Bearing
Lower Blade Guides..... Ball Bearing

Table Information

Table Length..... 24 in.
Table Width..... 28 in.
Floor to Table Height..... 35-1/4 in.

Fence Information

Locks in Front..... Yes
Locks in Rear..... No
Adjustable for Blade Lead..... Yes

Construction

Table..... Precision-Ground Cast Iron
Rip Fence Deluxe Extruded Aluminum & Cast Iron
Body..... One-Piece Reinforced Steel
Upper Wheel..... Computer-Balanced Cast Iron
Lower Wheel..... Computer-Balanced Cast Iron
Tire..... Rubber
Wheel Cover Pre-Formed Steel
Paint..... Powder Coated

Other Related Information

Wheel Diameter..... 19 in.
Wheel Width..... 1-13/16 in.
Number of Dust Ports..... 2
Dust Port Size..... 4 in.
Mobile Base..... G7315Z

Other Specifications:

Country Of Origin Taiwan
Warranty 1 Year
Serial Number Location ID Label on Upper Wheel Cover
Customer Assembly & Setup Time 1 Hour



SECTION 1: SAFETY

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures. Always use common sense and good judgement.



Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the machine.

WARNING

OWNER'S MANUAL. Read and understand this owner's manual **BEFORE** using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS. You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To do any electrical work, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply **BEFORE** making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are not approved safety glasses.

Safety Instructions for Machinery



WARNING

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips, which could cause loss of workpiece control.

HAZARDOUS DUST. Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

INTENDED USAGE. Only use machine for its intended purpose and never make modifications not approved by Grizzly. Modifying machine or using it differently than intended may result in malfunction or mechanical failure that can lead to serious personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine **OFF** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

CHECK DAMAGED PARTS. Regularly inspect machine for any condition that may affect safe operation. Immediately repair or replace damaged or mis-adjusted parts before operating machine.

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.



WARNING

Additional Safety for Bandsaws

BLADE CONDITION. Do not operate with dull, cracked or badly worn blade. Dull blades require more effort to perform the cut. Inspect blades for cracks and missing teeth before each use.

HAND PLACEMENT. Never position fingers or hands in line with the blade. If the workpiece or your hands slip, serious personal injury could occur.

WORKPIECE MATERIAL. This machine is intended for cutting natural and man-made wood products, and laminate covered wood products. This machine is NOT designed to cut metal, glass, stone, tile, etc.

BLADE REPLACEMENT. To avoid mishaps that could result in operator injury, make sure the blade teeth face down toward the table and the blade is properly tensioned and tracked before operating.

BLADE SPEED. Moving the workpiece against a blade that is not at full speed could cause kick-back. Always allow the blade to come to full speed before starting the cut.

GUARDS. The blade guard protects the operator from the moving bandsaw blade. ONLY operate this bandsaw with the blade guard installed.

CUTTING TECHNIQUES. Plan your cuts so you always cut out of the wood. DO NOT back the workpiece away from the blade while the saw is running. If you need to back the work out, turn the bandsaw OFF and wait for the blade to come to a complete stop, and DO NOT twist or put excessive stress on the blade while backing the work away.

LEAVING WORK AREA. Never leave a machine running unattended. Allow the bandsaw to come to a complete stop and use the padlock to disable the machine before you leave it unattended.

FEED RATE. To avoid the risk of the workpiece slipping and causing operator injury, always feed stock evenly and smoothly. DO NOT force or twist the blade while cutting, especially when sawing small curves.

SMALL WORKPIECE HANDLING. Always support/feed the workpiece with push sticks, jig, vise, or some type of clamping fixture. If your hands slip during a cut while holding small workpieces with your fingers, amputation or laceration injuries could occur.

BLADE CONTROL. To avoid serious personal injury, DO NOT attempt to stop or slow the blade with your hand or the workpiece. Allow the blade to stop on its own.

WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

CAUTION

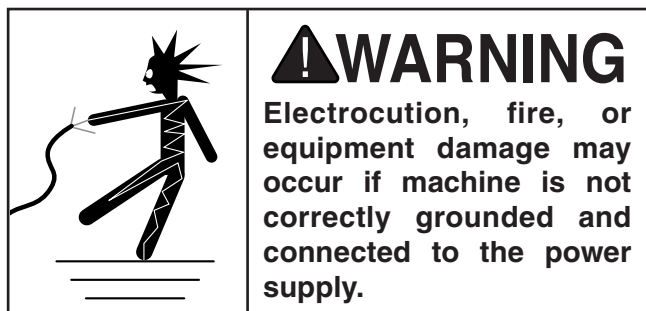
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.



SECTION 2: POWER SUPPLY

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.



Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 230V 22 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

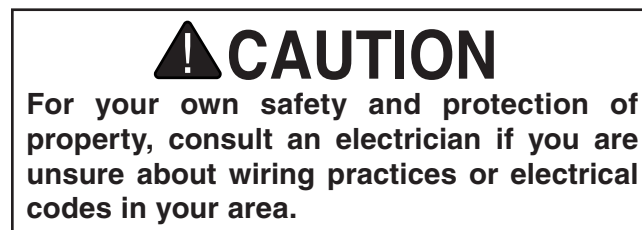
If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the requirements in the following section.

Circuit Requirements for 230V

This machine is prewired to operate on a 230V power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 230V
Cycle 60 Hz
Phase 1-Phase
Power Supply Circuit 30 Amps
Plug/Receptacle NEMA L6-30
Cord “S”-Type, 3-Wire, 12 AWG, 300 VAC

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)



Note: *The circuit requirements listed in this manual apply to a dedicated circuit—where only one machine will be running at a time. If this machine will be connected to a shared circuit where multiple machines will be running at the same time, consult a qualified electrician to ensure that the circuit is properly sized for safe operation.*



Grounding Instructions

This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

The power cord and plug specified under “Circuit Requirements for 230V” on the previous page has an equipment-grounding wire and a grounding prong. The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances (see following figure).

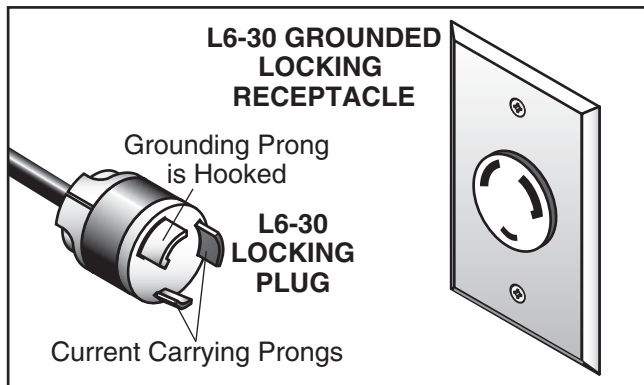
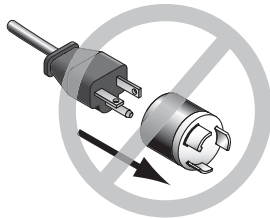


Figure 3. Typical L6-30 plug and receptacle.

!WARNING

Serious injury could occur if you connect the machine to power before completing the setup process. DO NOT connect to power until instructed later in this manual.

!CAUTION



No adapter should be used with the required plug. If the plug does not fit the available receptacle, or the machine must be reconnected for use on a different type of circuit, the reconnection must be made by a qualified electrician and comply with all local codes and ordinances.

!WARNING

Serious injury could occur if you connect the machine to power before completing the setup process. DO NOT connect to power until instructed later in this manual.

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

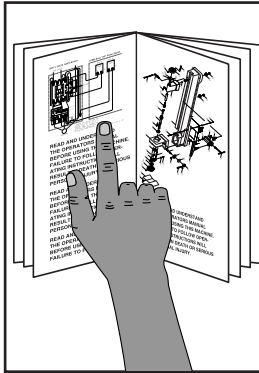
Extension cords cause voltage drop, which may damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must contain a ground wire, match the required plug and receptacle, and meet the following requirements:

Minimum Gauge Size 10 AWG
Maximum Length (Shorter is Better).....50 ft.

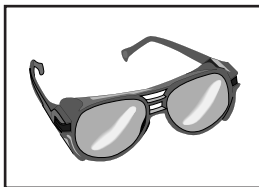


SECTION 3: SETUP



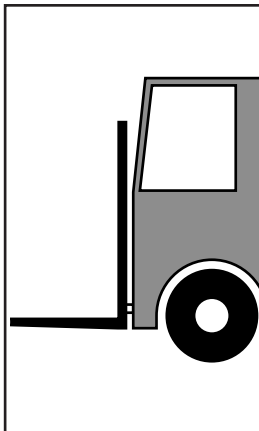
!WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



!WARNING

Wear safety glasses during the entire setup process!



!WARNING

The Model G0701 is a heavy machine. Serious personal injury may occur if safe moving methods are not used. To be safe, get assistance and use power equipment to move the shipping crate and remove the machine from the crate.

Needed for Setup

The following are needed to complete the setup process, but are not included with your machine.

Safety

- Safety Glasses
- Heavy Leather Gloves

Lifting/Moving The Bandsaw

- Forklift/Hoist w/1000 lb. Capacity
- Chains/Straps w/Safety Lifting Hooks

Cleaning

- Cleaner/Degreaser
- Disposable Shop Rags

Assembly & Adjustments

- Hex Wrench 5mm
- Hex Wrench 6mm
- Wrench 17mm
- Wrench or Socket 19mm
- Phillips Screwdriver
- Machinist's Square
- 3' Straightedge
- Finely Incremented Ruler
- Dust Collection System
- Two 4" Dust Hoses w/Clamps

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover the machine is damaged, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.



Inventory

The following is a description of the main components shipped with your machine. Lay the components out to inventory them.

Note: *If you can't find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.*

| Inventory: (Figure 4) | Qty |
|---|-----|
| A. Bandsaw (Not Shown)..... | 1 |
| B. Standard Fence Assembly | 1 |
| C. Resaw Fence | 1 |
| D. Miter Gauge Assembly | 1 |
| E. Resaw Fence Lock Lever M8-1.25 x 45..... | 1 |
| F. Flat Washer 8mm (Resaw Fence)..... | 1 |
| G. Resaw Fence T-Bar..... | 1 |
| H. Lifting Eye Bolts M12-1.75 x 20 | 2 |

If any nonproprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

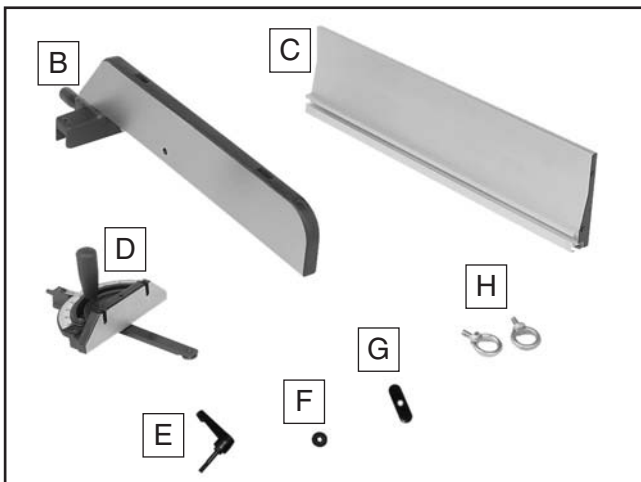


Figure 4. G0701 inventory.

| | |
|--|--|
| | <p>⚠ WARNING SUFFOCATION HAZARD! Immediately discard all plastic bags and packing materials to eliminate choking/suffocation hazards for children and animals.</p> |
|--|--|

Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

- Disposable Rags
- Cleaner/degreaser (WD•40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

| |
|--|
| <p>NOTICE Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.</p> |
|--|



Site Considerations

Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. **See below for required space allocation.**

| | |
|---|---|
|  | <p>CAUTION Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.</p> |
|---|---|

Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave access to a means of disconnecting the power source or engaging a lockout/tagout device, if required.

Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

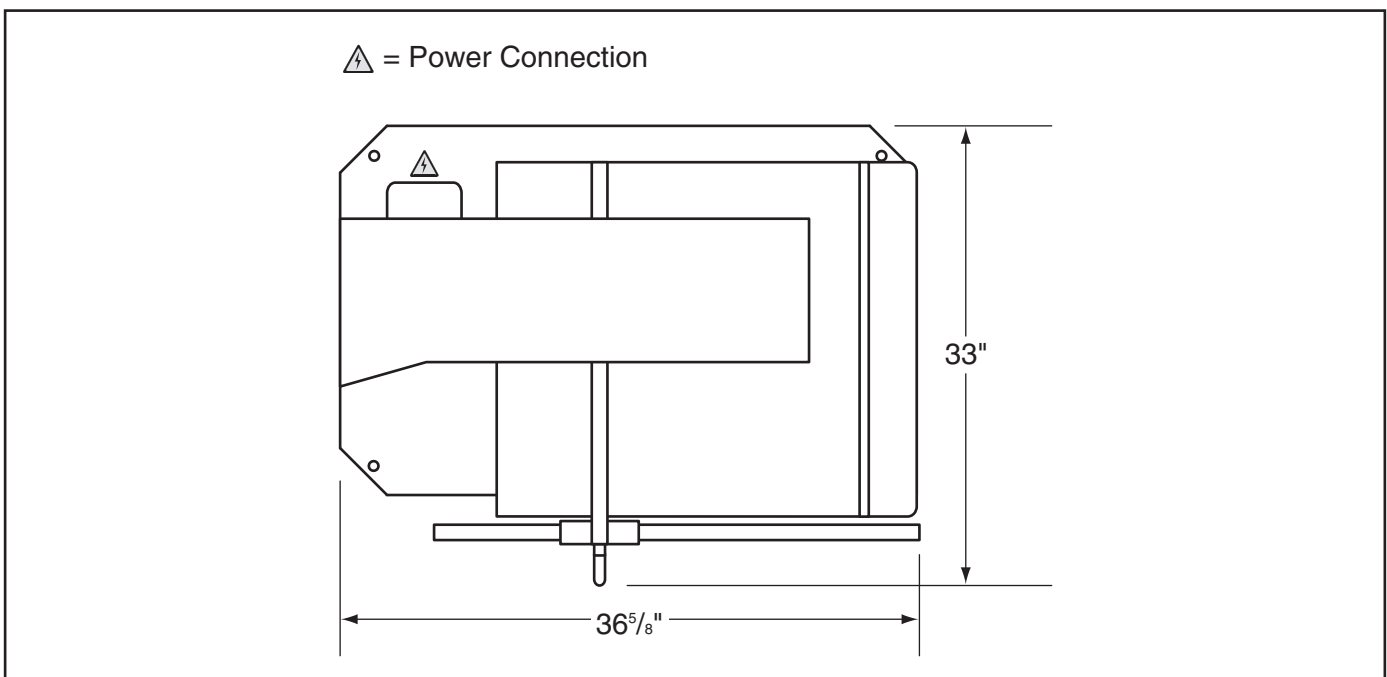
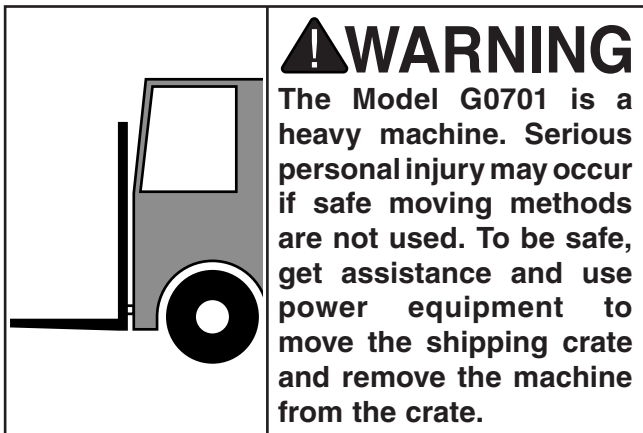


Figure 5. Minimum working clearances.



Moving & Placing Bandsaw



Take special care when lifting and moving the Model G0701. Use only one of the following methods to place your bandsaw in its operating location.

Using Lifting Eye Bolts

1. With the help of another person to steady the load, use the forklift to move the shipping pallet and bandsaw to its operating location.
2. Remove the shipping crate from the pallet.
3. Install the lifting eye bolts, as illustrated in **Figure 6**, making sure they are threaded all the way in.

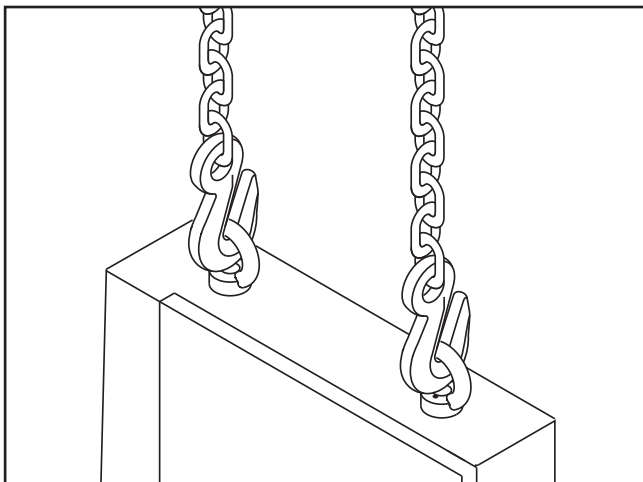


Figure 6. Lifting eye bolts installed.

4. Unbolt the bandsaw from the shipping pallet.
5. Attach the safety lifting hooks and chains/straps (rated for at least 1000 lbs.) to the eye bolts and forklift/hoist, then slowly lift the bandsaw.
6. Carefully remove the shipping pallet and place the bandsaw on the floor.
7. Mount the machine to the floor with one of the options outlined in the next subsection.

Using Wood Shims

1. With the help of another person to steady the load, use the forklift to move the shipping pallet and bandsaw to its operating location.
2. Remove the shipping crate from the pallet.
3. Unbolt the bandsaw from the shipping pallet.
4. Carefully position the forks of the forklift under the bandsaw head, as shown in **Figure 7**, then place a 1x4 wood shim between the head and the right fork and a 2x4 wood shim between the head and the left fork.

Note: *If you are concerned about your forklift forks hitting the tension handwheel, remove it for this step, then re-install it afterward.*

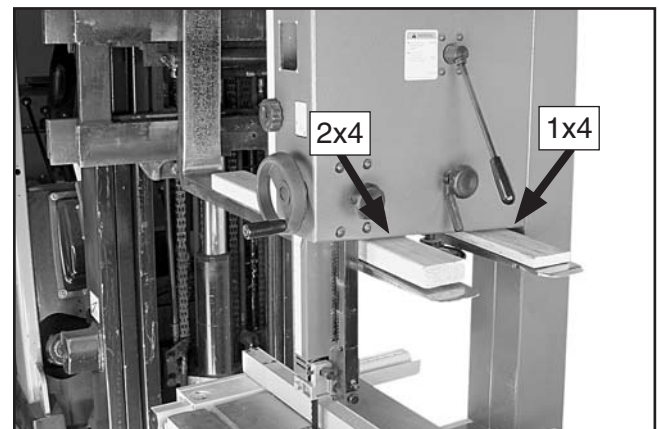


Figure 7. Using wood shims to lift the bandsaw.

5. With the help of another person to steady the load, carefully lift the bandsaw, remove the shipping pallet, then place the machine on the floor.
6. Mount the machine to the floor with one of the options outlined in the next subsection.



Mounting to Shop Floor

Although not required, we recommend that you mount your new bandsaw to the floor. Because this is an optional step and floor materials may vary, floor mounting hardware is not included. Generally, you can bolt your machine to the floor, mount it on machine mounts, or secure it to a mobile base (see **Figure 10**). These options are described below. Whichever option you choose, it is necessary to level your machine with a precision level.

Bolting to Concrete Floors

Anchor studs and lag shield anchors with lag bolts (**Figure 8**) are two popular methods for anchoring your bandsaw to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

NOTICE

Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, which may cause a tripping hazard if you decide to move your machine.

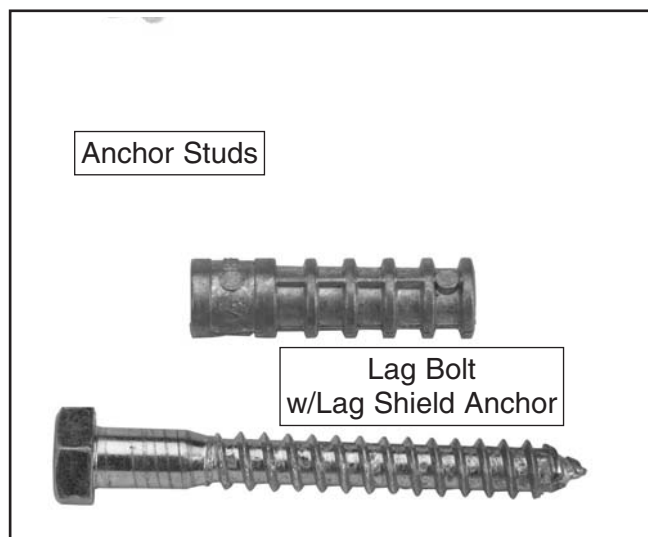


Figure 8. Typical fasteners for mounting to concrete floors.

Using Machine Mounts

Using machine mounts, shown in **Figure 9**, gives the advantage of fast leveling and vibration reduction. The large size of the foot pads distributes the weight of the machine to reduce strain on the floor.



Figure 9. Machine mount example.

NOTICE

We strongly recommend securing your machine to the floor if it is hardwired to the power source. Consult with your electrician to ensure compliance with local codes.



Figure 10. Bandsaw mounted on a G7315Z SHOP FOX® Mobile Base.



Setup Procedures

Before connecting your bandsaw to power for the first time and performing the **Test Run** on **Page 20**, you **MUST** successfully complete the following tasks in the following order per the instructions on the referenced pages:

- Make sure the blade is tracking properly (**Page 16**).
- Adjust the positive stop bolt (**Page 17**).
- Assemble the fence (**Page 19**).
- Connect the bandsaw to an adequate dust collection system (**Page 20**).

Blade Tracking



Blade tracking is affected by the tilt of the upper wheel (known as center tracking) and the alignment of both wheels (known as coplanar tracking).

The wheels on this bandsaw were aligned at the factory, so center tracking is the only adjustment that needs to be performed when the saw is new (refer to the **Aligning Wheels** subsection on **Page 60** for detailed instructions on coplanar tracking).

Note: *Changes in the blade tension may change the blade tracking. For best performance, regularly check and maintain the proper blade tracking.*

To center track the blade:

1. DISCONNECT BANDSAW FROM POWER!
2. Adjust the upper and lower blade guides away from the blade (refer to **Adjusting Blade Guide Bearings** on **Page 29** for detailed instructions).

Note: *When adjusting the blade tracking, the blade must have a reasonable amount of tension to simulate operating conditions. After the **Test Run** is successfully completed, you will perform a thorough version of the following steps to correctly tension the blade.*

3. Move the blade tension quick release lever all the way right (as viewed from the rear of the machine) to apply tension to the blade (see **Figure 11**).

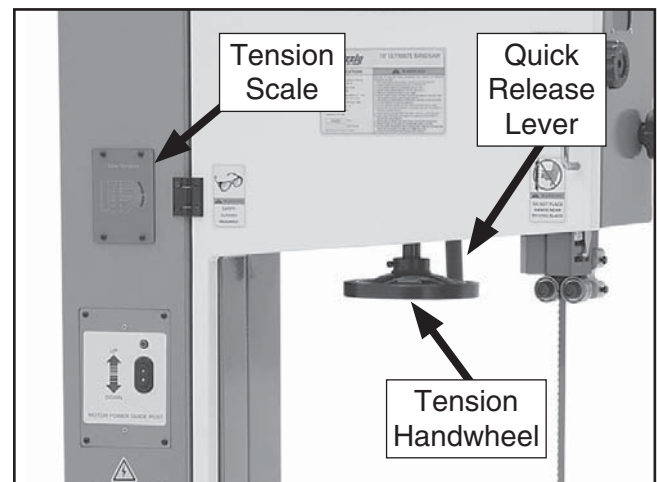


Figure 11. Blade tension controls.

4. Use the tension handwheel to bring the pointer on the tension scale to the appropriate mark for the blade width.



5. Open the upper wheel cover.
6. Rotate the upper wheel by hand several times (at least three) and watch how the blade rides on the wheel crown. See **Figure 12** for an illustration of this concept.

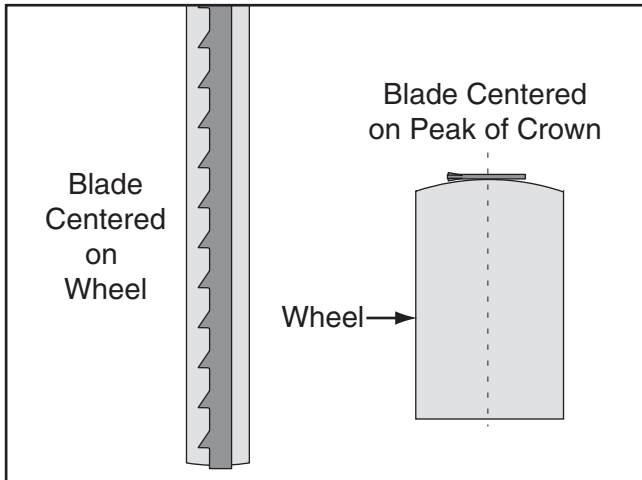


Figure 12. Blade center tracking profiles.

—If the blade rides in the center of the upper wheel and is centered on the peak of the wheel crown, then the bandsaw is already properly center-tracked and no further tracking adjustments are needed at this time.

—If the blade does NOT ride in the center of the upper wheel and is not centered on the peak of the wheel crown, then continue with this procedure.

7. Loosen the blade tracking lock lever so that the blade tracking knob can rotate (see **Figure 13**).

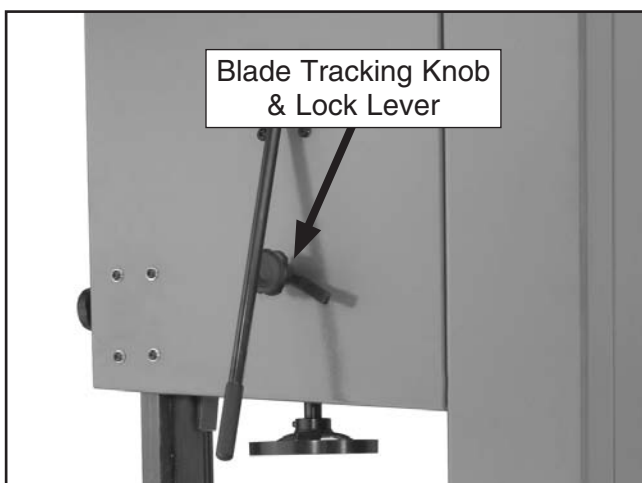


Figure 13. Blade tracking knob and lock lever.

Note: When the tracking knob is rotated, the lower portion of the upper wheel will tilt out or in, which affects the way the blade tracks.

8. Spin the upper wheel with one hand and slowly adjust the tracking knob with the other until the blade rides in the center of the wheel tire without wandering.
9. Tighten the lock lever to secure the setting, then spin the upper wheel again to confirm the tracking. If necessary, repeat **Steps 6–8** until you are satisfied with the blade tracking.
10. Re-adjust the blade guide bearings toward the blade (refer to **Page 29**).
11. Close and secure the upper wheel cover before beginning operation.

Adjusting Positive Stop

After using the table at a tilt of other than 0°, the positive stop allows the table to be quickly and accurately returned to the horizontal position in relation to the blade. This is important for accurate cutting results.

To correctly set the positive stop:

1. Correctly set the blade tension and use the guide post elevation control to move the guide post all the way up.
2. DISCONNECT BANDSAW FROM POWER!



- Loosen the table tilt lock handle, then use the table tilt handwheel to raise the table (see **Figure 14**).

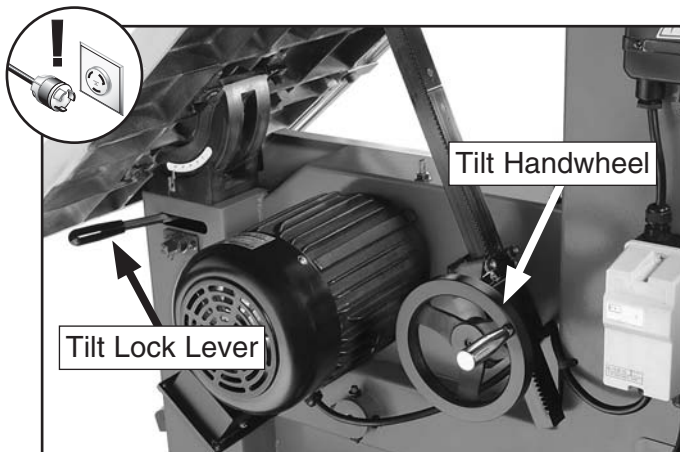


Figure 14. Table tilted up.

- Open both wheel covers, use a 17mm wrench to loosen the positive stop jam nut shown in **Figure 15**, then lower the positive stop bolt so that it will not interfere with the table tilt in the following steps.



Figure 15. Positive stop bolt and jam nut.

- Lower the table and place a machinist's square flat on the table and against the side of the blade, as illustrated in **Figure 16**.

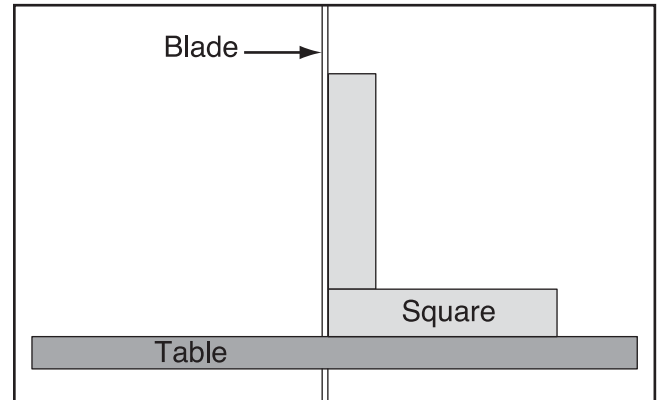


Figure 16. Squaring table to the blade.

- Use the table tilt handwheel to adjust the table square to the blade, then move the tilt lock lever to the right to secure the setting.
- Adjust the positive stop bolt up until it just touches the table, then re-tighten the jam nut to hold it in place.
- Re-check the table to make sure it is square to the blade. If necessary, repeat this procedure until you are satisfied.
- Loosen the screw on the table tilt scale pointer, but do not remove it (see **Figure 17**).

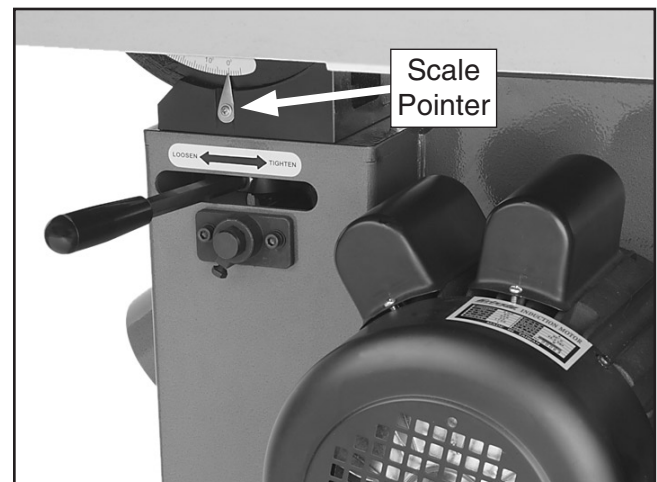


Figure 17. Table tilt scale pointer.

- Align the pointer tip with the zero on the scale, then re-tighten the screw.
- Close and secure both wheel covers before beginning operation.



Fence

The front fence rail is attached to the table upside down at the factory for shipping purposes.

Properly Attaching Fence Rail

1. Remove the three cap screws, lock washers, and flat washers shown in **Figure 18**.

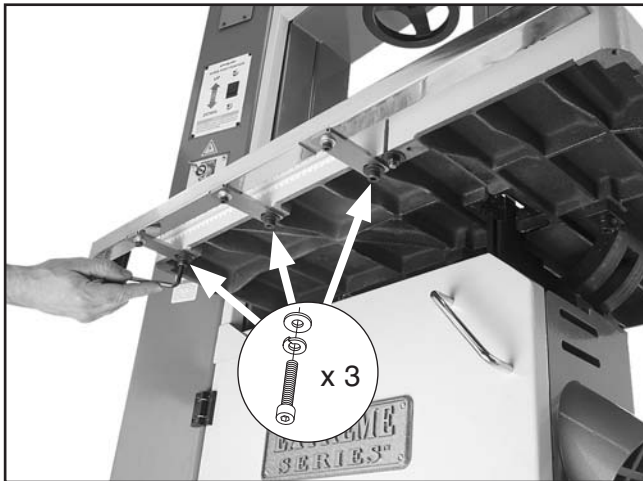


Figure 18. Fence rail in the correct position.

2. Flip the fence rail over and re-attach it with the fasteners removed in **Step 1**.

Assembling Resaw Fence

1. Slide the 8mm flat washer onto the resaw fence lock lever, then insert the assembly through the standard fence (see **Figure 19**).

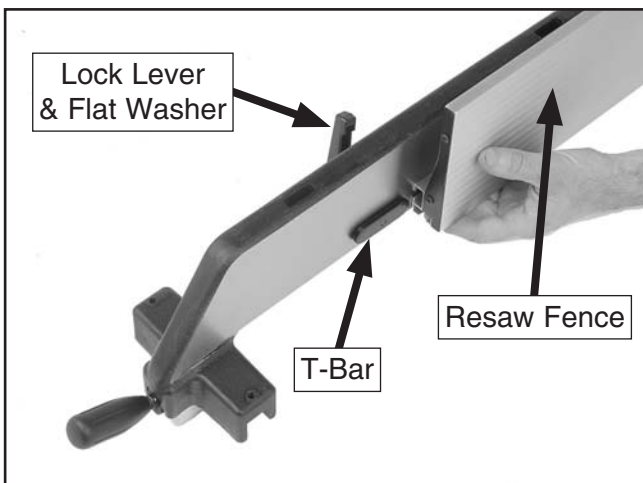


Figure 19. Resaw fence components.

2. Thread the T-bar onto the lock lever a couple of turns, align the resaw fence slot and the T-bar, then slide the resaw fence fully onto the standard fence, as shown in **Figure 19**.
3. Tighten the lock lever to secure the resaw fence in position.

Mounting Fence Assembly

1. Pull the fence handle up, then place the fence on the fence rail, as shown in **Figure 20**.



Figure 20. Fence assembly mounted on the fence rail.

2. To secure the fence in place, push down on the fence handle.



Dust Collection

⚠ CAUTION

DO NOT operate the Model G0701 without an adequate dust collection system. This saw creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Recommended CFM

At Each Dust Port: 400 CFM

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect a dust collection hose:

1. Fit a 4" dust hose over each dust port, as shown in **Figure 21**, then secure them in place with hose clamps.
2. Tug the hoses to make sure they do not come off. **Note:** A tight fit is necessary for proper performance.

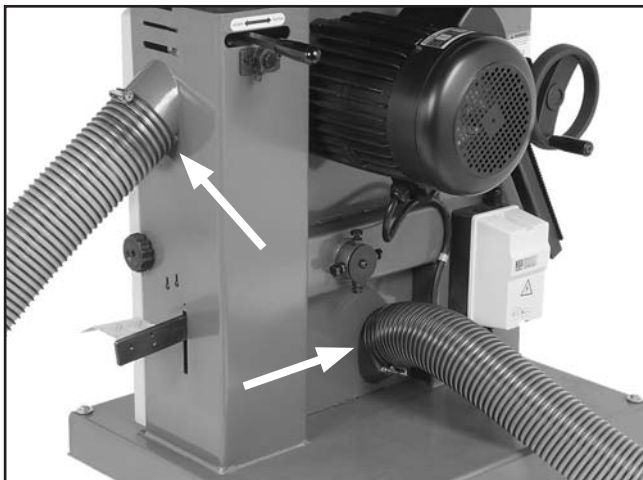


Figure 21. Dust hoses attached.

Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation. The test run consists of verifying the following:

1. The motor powers up and runs correctly.
2. The stop button and key switch safety features work correctly.
3. The guide post elevation motor powers up and runs correctly.
4. The foot brake is operating correctly.
5. The upper wheel cover safety switch operates correctly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting on Page 49**.

If you cannot find a remedy, contact our Tech Support at (570) 546-9663 for assistance.

⚠ WARNING

Before starting the bandsaw, make sure you have performed the preceding assembly and adjustment instructions, and you have read through the rest of the manual and are familiar with the various functions and safety features on this machine. Failure to follow this warning could result in serious personal injury or even death!

To test run the machine:

1. Make sure you understand the safety instructions at the beginning of the manual and that the machine is set up properly.
2. Make sure all tools and objects used during setup are cleared away from the machine and that nothing obstructs the blade movement.
3. Make sure both wheel covers are closed and secured.
4. Connect the machine to the power source.



5. Push the OFF button in, then twist it clockwise so it pops out. When the OFF button pops out, the switch is reset and ready for operation (see **Figure 22**).

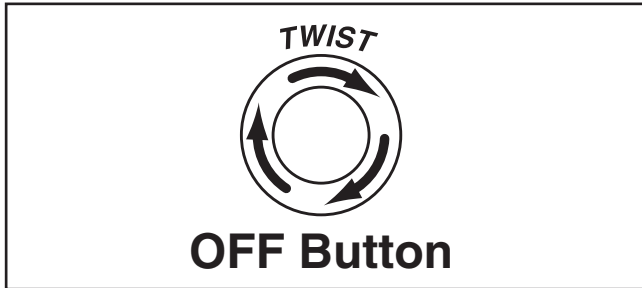


Figure 22. Resetting the OFF button.

6. Verify that the machine is operating correctly by turning the key switch to "1" (see **Figure 23**), then pushing the ON button.

—When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.

—Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.

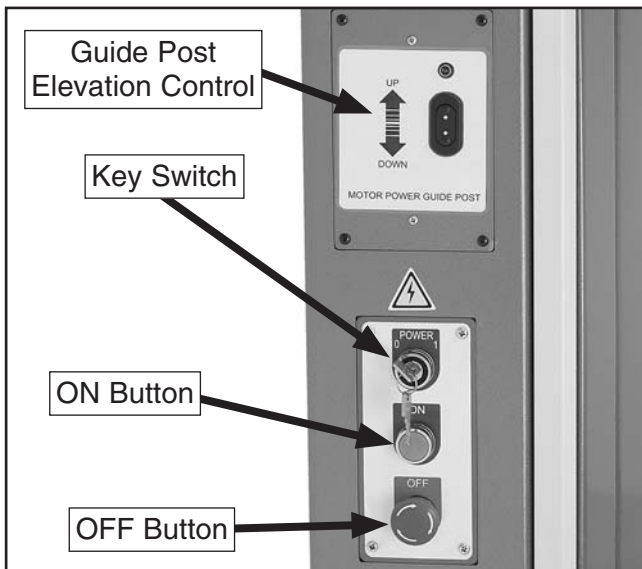


Figure 23. Control panel.

7. Press the OFF button to stop the machine.
8. WITHOUT resetting the OFF button, press the ON button. The machine should not start.

—If the machine does not start, the OFF button safety feature is working correctly.

—If the machine does start (with the stop button pushed in), immediately disconnect the machine from power. The OFF button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

9. Reset the OFF button, turn the key switch to "0", then press the ON button. The machine should not start.

—If the machine does not start, the key switch safety feature is working correctly.

—If the machine does start (with the key switch turned to "0"), immediately press the OFF button and disconnect the machine from power. The key switch safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

10. Turn the key switch back to "1", then use the guide post elevation control to raise and lower the guide post (see **Figure 23**).



Note: When the foot brake is used, a "kill" switch stops the flow of power to the machine. It is the steady pressure on the foot brake that quickly brings the blade to a full stop.

11. Start the machine, then apply steady pressure to the foot brake.

—If the machine turns **OFF** and the blade comes to a rapid stop, the foot brake system is working properly.

—If the machine does NOT turn **OFF**, the foot brake system is not working correctly. Immediately press the OFF button and disconnect the machine from power. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

12. Press the OFF button, wait for the blade to come to a complete stop, then open the upper wheel cover approximately 1" to activate the safety switch.

Note: This safety switch is designed to interrupt power to the motors when the door is open.

13. While standing to the left of the machine and away from the open wheel cover, reset the OFF button and press the ON button. The machine should NOT start.

—If the machine does not start, the upper wheel cover safety switch feature is working correctly. The **Test Run** is complete.

—If the machine does start, immediately press the OFF button and disconnect the machine from power. The upper wheel cover safety switch is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

Additional Adjustments

After successfully completing the **Test Run**, the adjustment procedures listed below must be performed to ensure safe and accurate cutting operations (refer to the following subsections for detailed instructions):

- Properly tension the blade (**Page 23**).
- Align the table with the blade (**Page 23**).
- Square the miter gauge body to the blade (**Page 24**).
- Align the fence with the blade (**Page 25**).
- Calibrate the fence pointer (**Page 26**).
- Aligning the blade guide and support bearings (**Page 26**).

Tensioning Blade

A properly tensioned blade is essential for making accurate cuts, extending the life of the blade, and making many other bandsaw adjustments. For instance, every time you replace the blade, you must perform this procedure because all blades tension differently.

Note: Before you performed the **Test Run**, you set the blade to its approximate tension. The following procedure fine-tunes the blade tension to ensure accurate cutting results.

To correctly tension the bandsaw blade:

1. Make sure the bandsaw is turned **OFF** and the blade has come to a complete stop.
2. Use the guide post elevation control to raise the guide post all the way up, then move the upper and lower guide/support bearings as far away from the blade as possible (refer to **Adjusting Blade Guide Bearings** on **Page 29** for detailed instructions).

Note: This procedure will NOT work correctly if the guide/support bearings are in contact with the blade.



3. Move the blade tension quick release lever all the way to the right (as viewed from the rear of the machine) to apply tension, then rotate the tension handwheel until the mark on the blade tension scale matches the one for the blade width (see **Figure 24**).

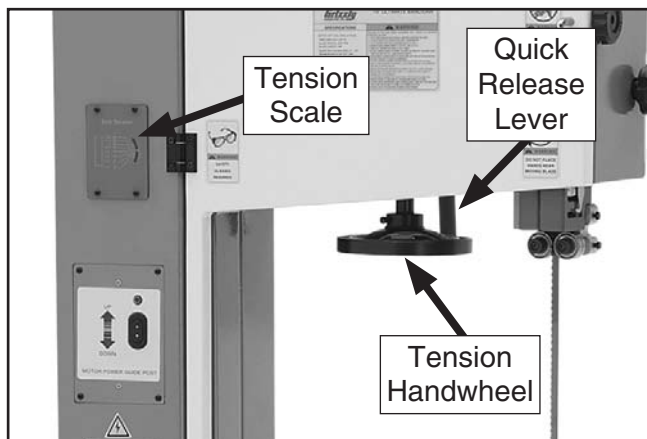


Figure 24. Blade tension controls.

4. Turn the bandsaw **ON** and wait for the blade to reach full speed.
5. Decrease blade tension very slowly by rotating the tension handwheel counterclockwise (as viewed from above) until the blade just starts to flutter or vibrate, then stop decreasing the tension.
6. Now, increase the tension by rotating the handwheel in the opposite direction (clockwise) until the blade stops fluttering, then rotate the handwheel another $\frac{1}{4}$ turn clockwise.
7. Turn the bandsaw **OFF**.
8. Re-adjust the blade tracking (**Page 16**) and the blade guides (refer to **Page 29**).

NOTICE

When not in use, move the tension quick release lever to the left to release blade tension, which will increase blade life and reduce machine wear.

Aligning Table

To ensure cutting accuracy with the miter gauge and fence, the table must be aligned with the blade. This is a process of aligning the table miter slot so that it is parallel with the blade, and is best done with a wide blade (1" or more).

To align the table with the blade:

1. Make sure the blade is properly tensioned (**Page 22**) and tracking correctly (**Page 16**).
2. **DISCONNECT BANDSAW FROM POWER!**
3. Place the straightedge flat on the table and across the blade so that it lightly touches both the front and back of the blade without touching a tooth, as shown in **Figure 25**.

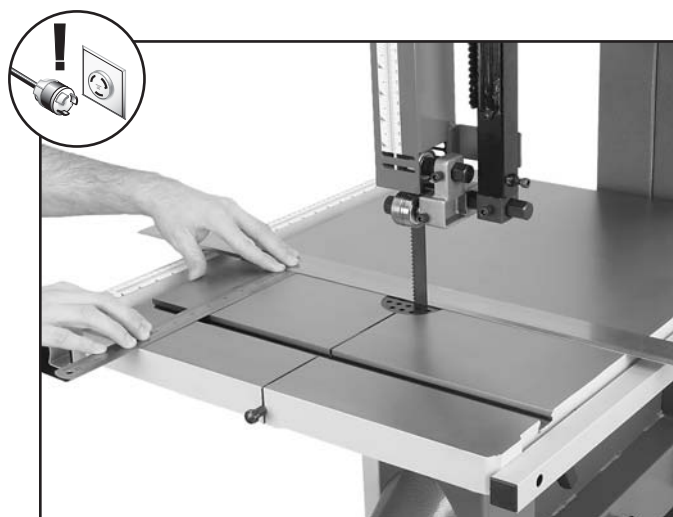


Figure 25. Example of measuring the table miter slot to be parallel with the blade.



- Use the finely incremented ruler and record the distance between the miter slot and the front and back of the straightedge.

—If the distances are the same, no further adjustments are needed.

—If there is a difference between the distances from the miter slot and the straightedge, continue with this procedure.

- From underneath the table, loosen the four trunnion cap screws that secure the table (see **Figure 26**).

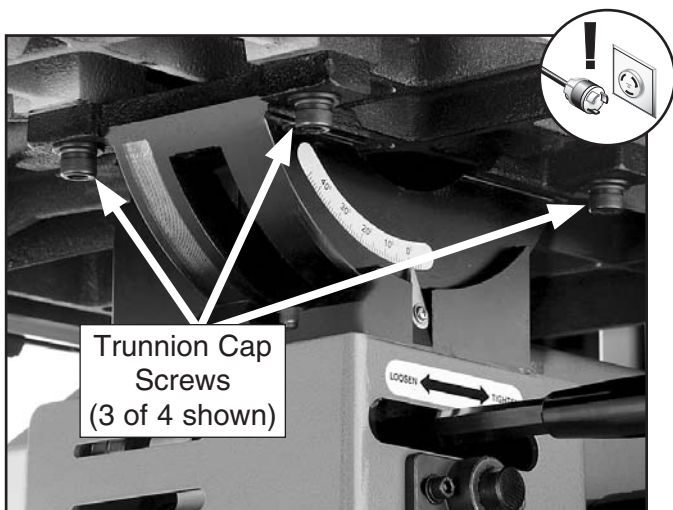


Figure 26. Trunnion cap screws (3 of 4 shown).

- Shift the table until the distances between the miter slot and straightedge are equal, as measured in **Step 4**.
- Re-tighten the trunnion cap screws, then repeat **Step 4**. If necessary, repeat **Steps 4–6** until you are satisfied.

Aligning Miter Gauge Body

To ensure accurate cutting results when using the miter gauge, the miter gauge body must be aligned with the blade.

To align the miter gauge body:

- Make sure the blade is properly tensioned (**Page 22**) and tracking correctly (**Page 16**).
- Install the widest blade possible and correctly tension it.
- DISCONNECT BANDSAW FROM POWER!**
- Lay the machinist's square flat on the table and up against the blade without touching any blade teeth, as shown in **Figure 27**.

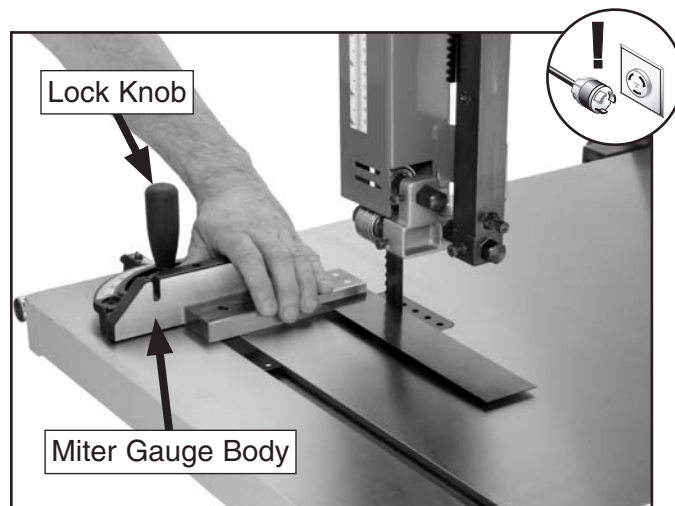


Figure 27. Aligning the miter gauge body with the blade.

- Without moving the square, bring the miter gauge body up to the square, as shown in **Figure 27**.

—If there are no gaps between the miter gauge body and the square, no further adjustments are needed.

—If there are gaps between the miter gauge body and the square, continue with this procedure.



6. Loosen the miter gauge lock knob and rotate the gauge body until it is flat against the square, then re-tighten the lock knob.
7. Loosen the screw that secures the miter gauge pointer, set the pointer to the 0° mark on the scale, then re-tighten the screw.

Aligning Fence

The fence must be aligned with the blade to ensure accurate cutting results. This is best done by aligning the fence with the miter slot after the table is properly aligned.

To align the fence with the table:

1. Make sure the blade is properly tensioned (**Page 22**) and tracking correctly (**Page 16**).
2. DISCONNECT BANDSAW FROM POWER!
3. Make sure the table is properly aligned with the blade, as instructed in the previous subsection.
4. If attached, remove the resaw fence.
5. Mount the fence on the right side of the blade and even with the miter slot, as shown in **Figure 28**.

—If the fence face is even with the miter slot from front-to-back, no further adjustments are necessary.

—If the fence face is not even with the miter slot along its length, continue with this procedure.



Figure 28. Fence even with the miter slot.

Model G0701 (Mfg. Since 3/12)

6. Loosen the cap screws that secure the fence rail to the table (see **Figure 29**),



Figure 29. Fence rail cap screws.

7. With the fence locked onto the fence rail, shift the fence rail until the fence is even with the miter slot along its entire length, then re-tighten the rail cap screws.
8. Slide the fence along the entire length of the rail to make sure it does not bind against the table.

—If the fence does bind against the table, re-loosen the rail cap screws and pull the rail away from the table, then repeat **Steps 7–8**.



Fence Pointer Calibration

After the fence is properly aligned with the table, which is aligned with the blade, the fence pointer must be calibrated to ensure quick and accurate positioning of the fence.

To calibrate the fence pointer:

1. Make sure the blade is properly tensioned (**Page 22**).
2. DISCONNECT BANDSAW FROM POWER!
3. Position the fence against the left side of the blade so that it is touching the blade without applying pressure to it, as shown in **Figure 30**, then lock the fence in place.



Figure 30. Fence against the blade.

4. Loosen the pointer adjustment screw shown in **Figure 31**, set the pointer in line with the "0" mark on the scale, then re-tighten the screw.

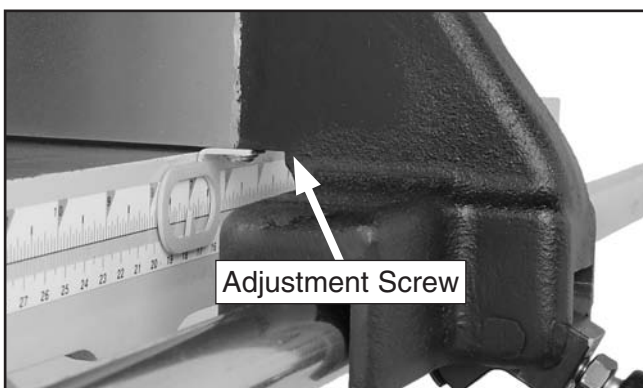


Figure 31. Fence pointer.

Aligning Blade Bearings

Proper alignment of the blade guide and support bearings with the blade is an important part of making accurate cuts. When correctly aligned, the guide bearings support but do not contact the blade teeth, and the support bearing keeps the blade from deflecting backwards with the force of cut.

Upper Blade Bearings

1. Make sure the blade is properly tensioned (**Page 22**) and tracking correctly (**Page 16**).
2. DISCONNECT BANDSAW FROM POWER!
3. Familiarize yourself with the upper blade bearing controls shown in **Figures 32–33**.

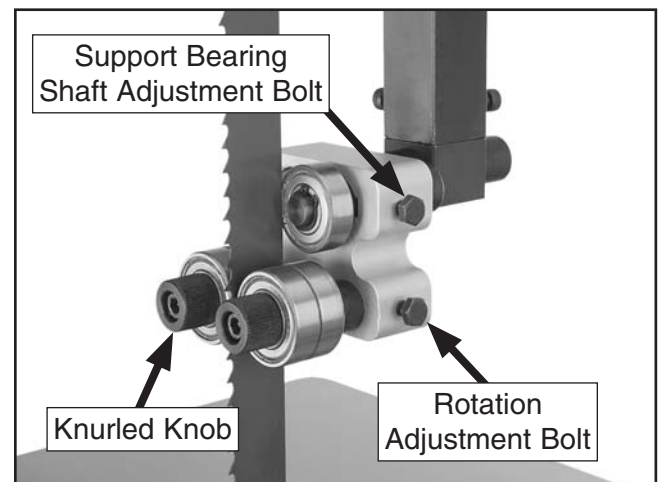


Figure 32. Front upper blade guide controls.

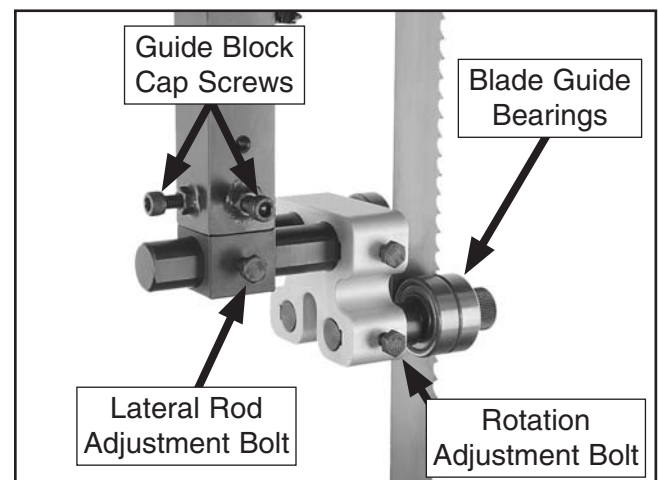


Figure 33. Rear upper blade guide controls.



Note: If you choose, you can remove the two lower cap screws and the upper hex bolt that secure the blade guard, then have another person hold the guard out of the way while you adjust the upper blade guide and support bearings.

Make sure to firmly secure the blade guard in place when you have completed the adjustment.

- Loosen the rotation adjustment bolts, then use the knurled knobs to move the guide bearings away from the blade.
- Loosen the guide block cap screws, then rotate the blade guide assembly side-to-side until the face of the support bearing is perpendicular (90°) to the blade, as illustrated in **Figure 34**.

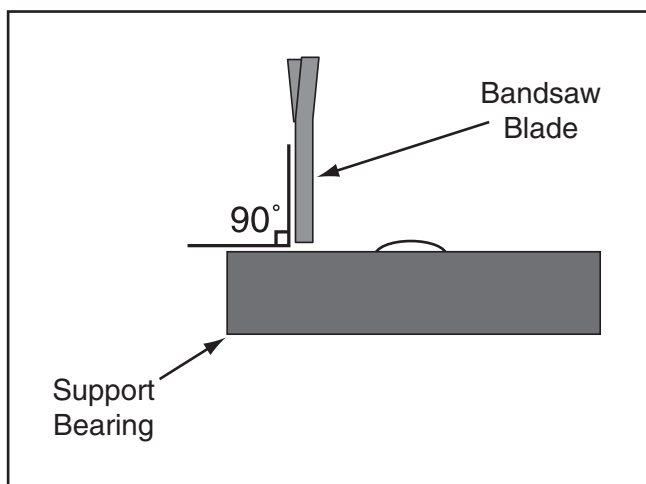


Figure 34. Support bearing 90° to the blade.

- Re-tighten the guide block cap screws to secure the support bearing position.
- Loosen the support bearing shaft adjustment bolt and the lateral rod adjustment bolt (see **Figures 32–33**).

- Adjust the blade guide bearings until the edges of the bearings are $\frac{1}{64}$ " (approximately the thickness of four pieces of paper) behind the blade gullets, as illustrated in **Figure 35**.

Note: With larger blades it may not be possible to reach the $\frac{1}{64}$ " spacing. In this case, adjust the bearings as far forward to the blade gullets as possible.

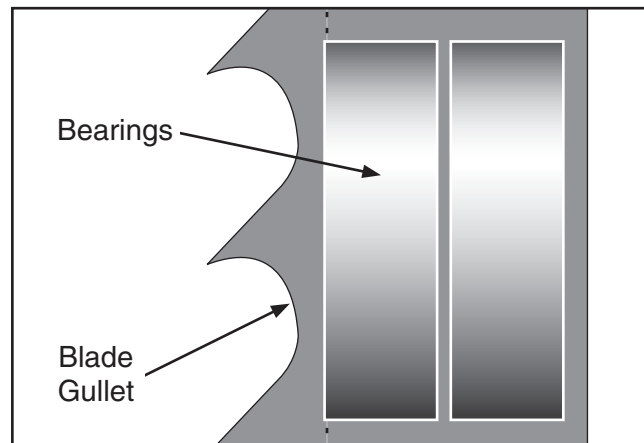


Figure 35. Lateral adjustment of guide bearings.

- Position the support bearing so that it is $\frac{1}{64}$ " (approximately the thickness of four pieces of paper) behind the blade, as illustrated in **Figure 36**.

Note: The goal is to position the support bearing so it will support the blade when pressure is applied during the cutting operation.

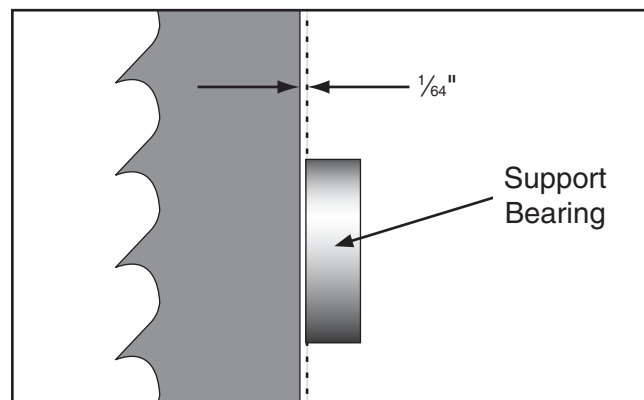


Figure 36. Support bearing properly positioned behind the blade.



10. Re-tighten the support bearing shaft adjustment bolt and the rotation adjustment bolts to secure the bearings in place.
11. Properly adjust the guide bearings (refer to **Adjusting Blade Guide Bearings** beginning on **Page 29** for detailed instructions).

Lower Blade Bearing

1. Make sure the blade is properly tensioned (**Page 22**) and tracking correctly (**Page 16**).
2. DISCONNECT BANDSAW FROM POWER!
3. Open both wheel covers, then familiarize yourself with the lower blade bearing controls shown in **Figures 37–39**.

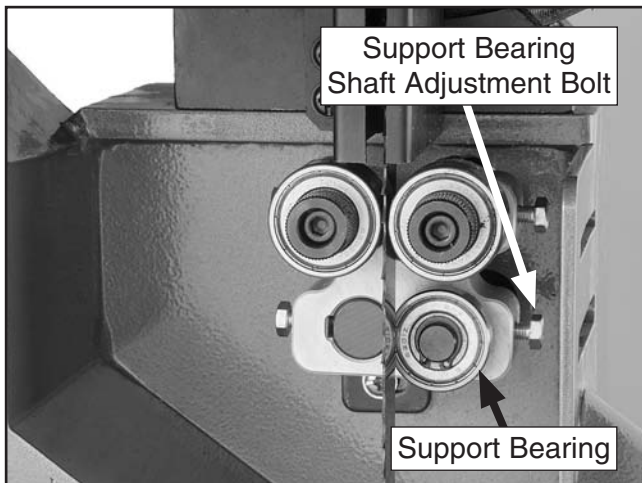


Figure 37. Lower support bearing controls.

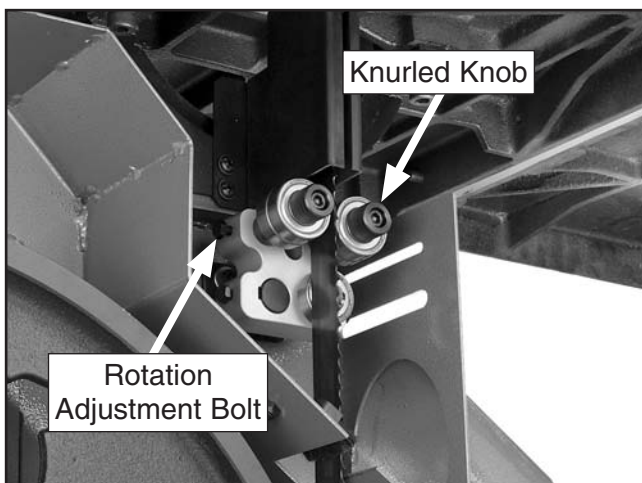


Figure 38. Front lower blade guide controls.

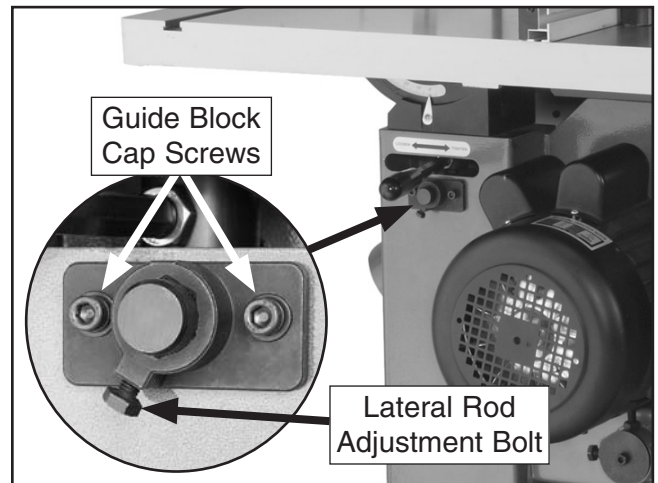


Figure 39. Rear lower blade guide controls.

4. To adjust the lower blade bearings, follow the same procedure used for the upper blade bearings beginning on the previous page.
5. Close and secure the lower and upper wheel covers.



Adjusting Blade Guide Bearings

When properly adjusted to the blade, the upper and lower blade guide bearings provide side-to-side support that keeps the blade straight while cutting.

Upper Blade Guide Bearings

1. Make sure the blade is properly tensioned (**Page 22**) and the blade tracking is correctly (**Page 16**).
2. DISCONNECT BANDSAW FROM POWER!
3. Make sure the blade guide and support bearings are properly aligned with the blade, as instructed on **Page 26**.
4. Familiarize yourself with the upper blade bearing controls shown in **Figures 40–41**.

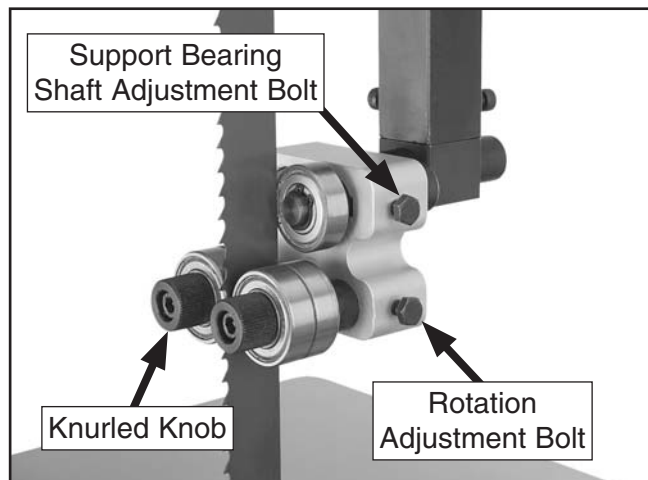


Figure 40. Front upper blade guide controls (blade guard removed for photo clarity).

Note: If you choose, you can remove the two lower cap screws and the upper hex bolt that secure the blade guard, then have another person hold the guard out of the way while you adjust the upper blade guide and support bearings.

Make sure to firmly secure the blade guard in place when you have completed the adjustment.

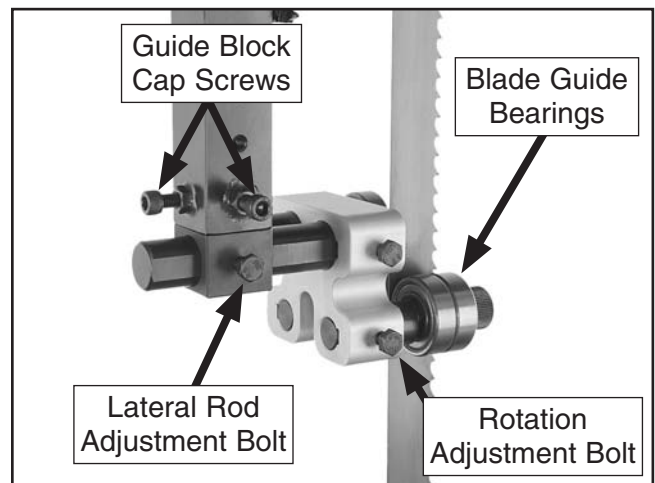


Figure 41. Rear upper blade guide controls (blade guard removed for photo clarity).

5. Loosen the rotation adjustment bolts on both sides of the blade (**Figures 40–41**).
6. Rotate the knurled knobs (**Figure 40**) to position the bearings as close to the blade as possible without touching it.

Note: Ideally, the bearings should be approximately 0.004" away from the blade, which is approximately the thickness of paper.

7. Re-tighten both rotation adjustment bolts to secure the blade bearings in place.



Lower Blade Guide Bearings

1. Make sure the blade is properly tensioned (**Page 22**) and tracking correctly (**Page 16**).
2. DISCONNECT BANDSAW FROM POWER!
3. Make sure the blade guide and support bearings are properly aligned with the blade, as instructed on **Page 26**.
4. Familiarize yourself with the lower blade bearing controls shown in **Figure 42**.

5. Open both wheel covers.
6. To adjust the lower blade guide bearings, follow the same procedure used for the upper blade guide bearings on the previous page.

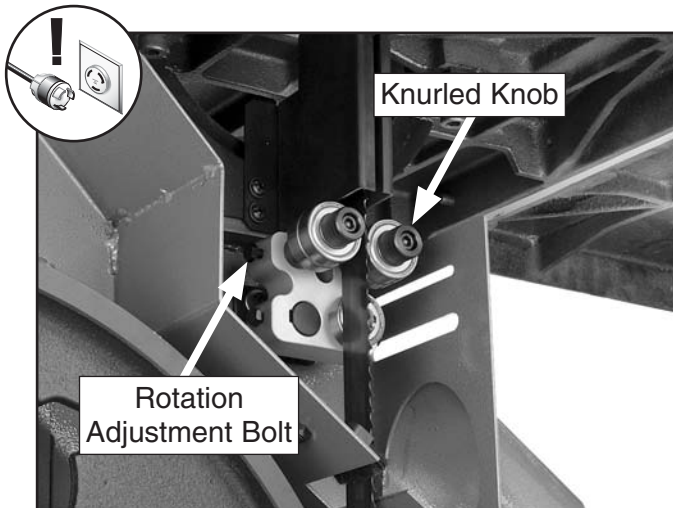
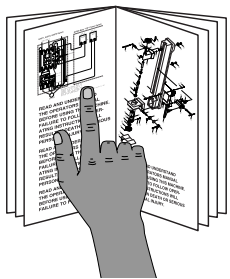


Figure 42. Front lower blade guide controls.

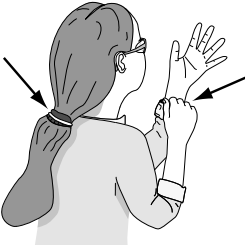




SECTION 4: OPERATIONS



!WARNING
To reduce the risk of serious injury when using this machine, read and understand this entire manual before beginning any operations.

!WARNING
Damage to your eyes and lungs could result from using this machine without proper protective gear. Always wear safety glasses and a respirator when operating this machine.



!WARNING
Loose hair, clothing, or jewelry could get caught in machinery and cause serious personal injury. Keep these items away from moving parts at all times to reduce this risk.

NOTICE
If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, review industry trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Basic Controls

Refer to **Figures 43–45** and the descriptions below to become familiar with the basic controls and components of your bandsaw.

Key Switch: Disables the ON and OFF button when the key is turned to the "0" position. Enables ON and OFF button when key is turned to "1".

ON Button: Starts motor only if the OFF button is popped out and the key switch key is turned to the "1" position.

OFF Button: Disables the ON button. Enable the ON button by twisting the OFF button clockwise until it pops out.

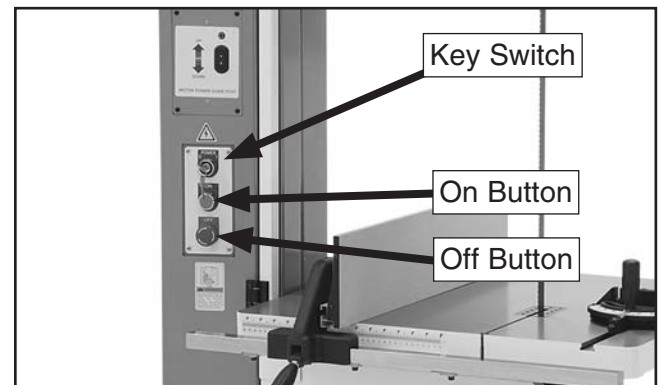


Figure 43. G0701 control panel features.



Front Controls (Figure 44)

- A. Blade Tension Scale:** Provides a way to gauge how much tension is applied to the blade.
- B. Blade Tracking Window:** Allows for easy monitoring of blade tracking (refer to **Page 16**).
- C. Guide Post Lock Knob:** Locks the guide post setting (refer to **Page 36**). The lock knob must be loosened before moving the upper blade guides with the guide post elevation control, or the motor could burn out.
- D. Fence, Rails, and Miter Gauge:** Allows for controlled cutting at various angles.
- E. Blade Tension Handwheel:** Tensions blade in gradual increments.
- F. Foot Brake:** Cuts power to motor and brings the blade to a quick stop.
- G. Guide Post Elevation Control:** Controls the powered guide post motor, which is used to raise or lower the guide post and upper blade guides to the desired height above the workpiece.

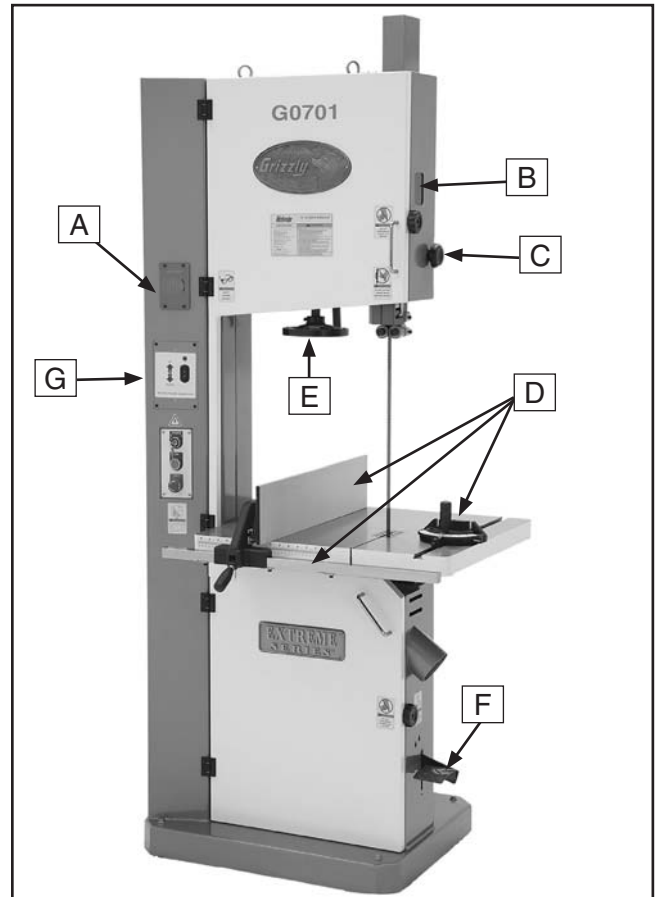


Figure 44. Front controls.

Rear Controls (Figure 45)

- H. Blade Tension Quick Release Lever:** Adjusts blade tension for quick blade changes.
- I. Blade Tracking Knob and Lock Lever:** Moves and locks blade tracking.
- J. Table Tilt Knob:** Tilts the table up to 5° to the left or 45° to the right.
- K. Table Tilt Lock Handle:** Locks or unlocks the table at the current angle.

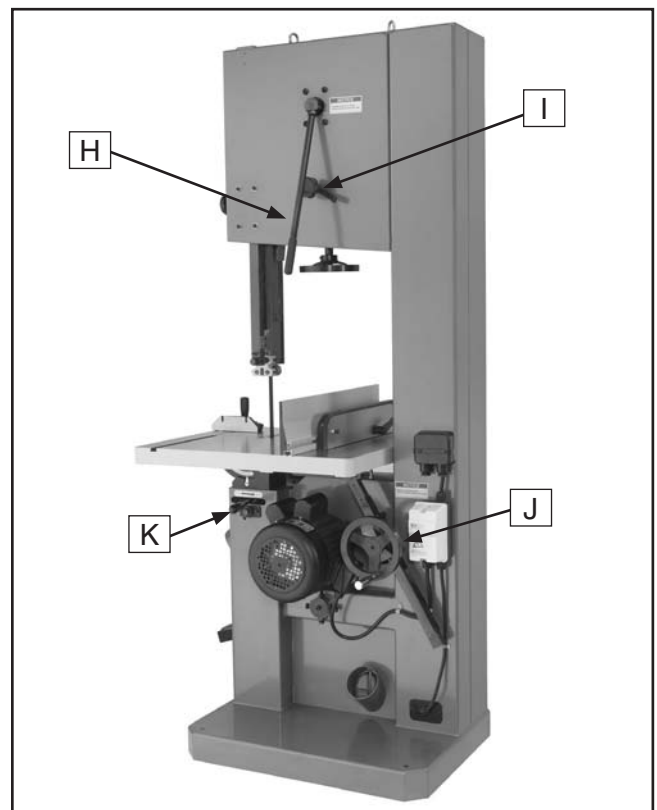


Figure 45. Rear controls.



Operation Overview

This overview covers the basic process that happens during a bandsaw operation. Familiarize yourself with this process to better understand the remaining parts of the **Operation** section.

To complete a typical operation, the operator does the following:

1. Examines the workpiece to make sure it is suitable for cutting.
2. Adjusts the fence for the width of the cut and then locks it in place.
3. Adjusts the table tilt, if necessary, to the correct angle of the desired cut.
4. Loosens the guide post lock knob, adjusts the blade guide height to between $\frac{1}{4}$ " and 1" from the top of the workpiece using the guide post elevation control, then tightens the guide post lock knob.
5. Checks to make sure the workpiece can safely pass all the way through the blade without interference from other objects.
6. Puts on safety glasses and a respirator.
7. Starts the dust collector and bandsaw.
8. Holds the workpiece firmly and flatly against both the table and fence, and then pushes the workpiece into the blade at a steady and controlled rate until the workpiece moves completely beyond the blade.

The operator is very careful to keep fingers away from the blade and uses a push stick to feed narrow workpieces.

9. Stops the bandsaw.

Cutting Overview

The bandsaw is capable of performing the following cuts:

- Miters
- Angles
- Resawing
- Ripping
- Crosscutting
- Compound Angles
- Simple/Complex Curves
- Duplicate Parts
- Circles
- Beveled Curves

Basic Cutting Tips

Here are some basic tips to follow when operating the bandsaw:

- Keep the upper blade guide assembly adjusted to within 1" of the workpiece.
- Use the correct blade for the operation.
- Replace, sharpen, and clean blades as necessary. Make adjustments periodically to keep the saw running in top condition.
- Use light and even pressure while cutting. Light contact with the blade makes it easier to follow lines and prevents extra friction, which reduces blade life.
- Avoid twisting the blade when cutting around tight corners. Allow the blade to saw around the corners.
- Do not back the workpiece away from the blade while the saw is running.



Workpiece Inspection

Some wood workpieces are not safe to cut or may require modification before they are safe to cut.

Before cutting wood, get in the habit of inspecting all workpieces for the following:

- **Material Type:** This machine is intended for cutting natural and man-made wood products, and laminate-covered wood products. Cutting drywall or cementitious backer board creates extremely fine dust, which may reduce the life of the bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.
- **Foreign Objects (Figure 46):** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While cutting, these objects can become dislodged and hit the operator or break the blade, which might then fly apart. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT cut the workpiece.
- **Large/Loose Knots:** Loose knots can become dislodged during the cutting operation. Large knots can cause blade damage. Choose workpieces that do not have large/loose knots or plan ahead to avoid cutting through them.
- **Wet or "Green" Stock:** Cutting wood with a moisture content over 20% causes unnecessary wear on the blade and yields poor results.
- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and can move unpredictably when being cut. DO NOT cut excessively warped wood.
- **Minor Warping:** Workpieces with slight cupping can be safely supported if the cupped side faces the table or fence, as shown in **Figure 47**. On the contrary, a workpiece supported on the bowed side will rock during a cut, leading to loss of control.

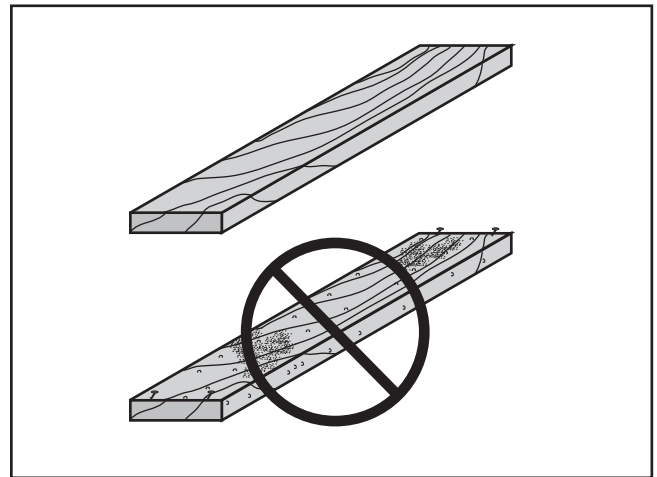


Figure 46. Choosing wood without foreign objects embedded.

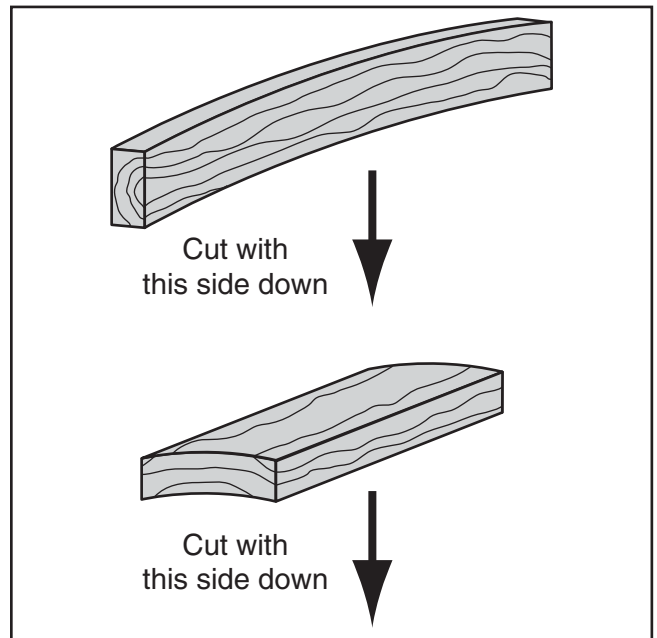


Figure 47. Cutting wood with minor warping.

⚠️ WARNING

Because of its unpredictable nature, use extreme caution if cutting warped stock. The difference between acceptable and unacceptable warped stock varies from machine to machine. If you are in doubt, square-up the stock first or do not cut it.



Foot Brake

The Model G0701 is equipped with a foot brake (Figure 48). Use the brake to cut power to the motor and bring the blade to a halt.

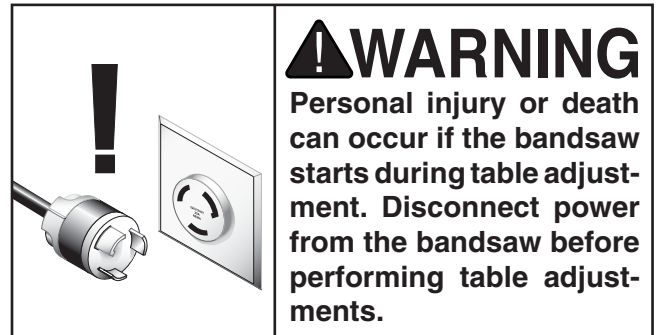
NOTICE

The foot brake will not stop the bandsaw wheels and blade instantly. DO NOT become over confident and relax your safety awareness because of the foot brake feature. Make sure the bandsaw blade has stopped moving completely before leaving the machine.



Figure 48. Foot brake location.

Table Tilt



The bandsaw table will tilt 5° left and 45° right to provide a wide range of cutting options.

To tilt the table:

1. DISCONNECT BANDSAW FROM POWER!
2. Loosen the table tilt lock handle shown in Figure 49.

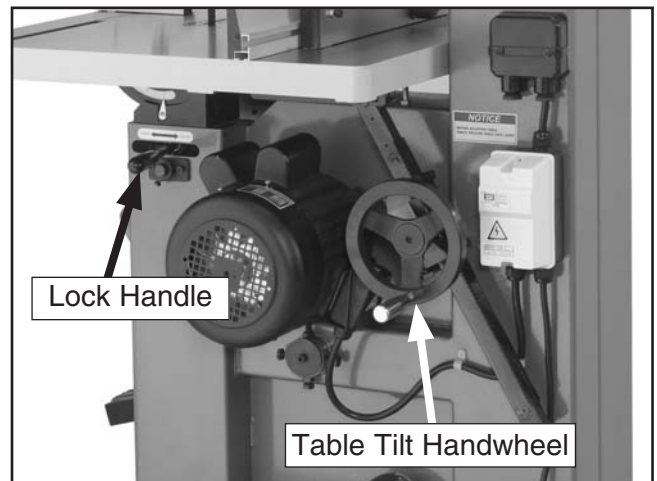


Figure 49. Table tilt controls.

3. To tilt the table to the right, turn the table tilt handwheel clockwise (Figure 49).
4. To tilt the table to the left, turn the table tilt handwheel clockwise one turn, lower the positive stop bolt, then turn the handwheel counterclockwise.
5. Secure the table tilt lock handle.
6. Follow "Positive Stop" instructions on Page 17 for resetting the stop bolt and table for horizontal (0°) operations.



Guide Post

The motorized guide post (see **Figure 50**) moves the blade guide assembly up or down. To cut accurately and safely, the bottom of the blade guide assembly must be no more than 1" above the workpiece during cutting operations—this positioning provides the greatest blade support and minimizes the length of moving blade that is exposed to the operator.

To adjust the guide post:

1. DISCONNECT BANDSAW FROM POWER!
2. Make sure that the blade tension, blade tracking, support bearings, and blade guides are adjusted correctly.
3. Loosen the guide post lock knob shown in **Figure 50**.

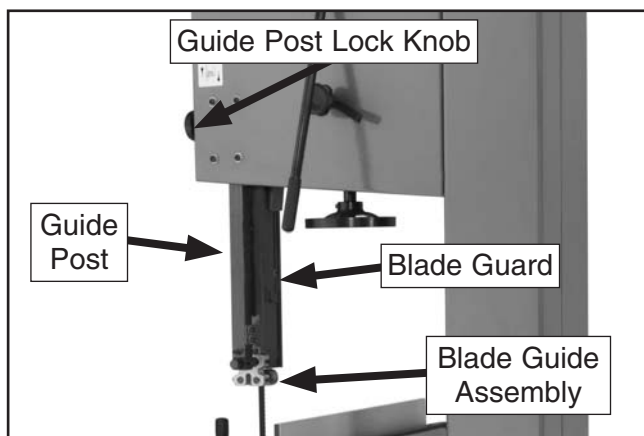


Figure 50. Guide post controls.

4. Press the guide post elevation control to raise or lower the guide post until the upper blade guide assembly is between ¼" and 1" from the top of the workpiece.

!WARNING

NEVER place fingers or hands under the motorized blade guide assembly. Your hand could be crushed or stuck between the blade guides and the workpiece. Failure to follow these warnings may result in serious personal injury!

5. Lock the guide post in place with the lock knob.

Fine Tune Tracking

NOTICE

Adjusting the final blade tracking setting requires the machine to be turned ON.

To fine tune the tracking:

1. Close the wheel covers and turn the bandsaw **ON**.
2. Observe the blade tracking path through the clear window on the right side of the bandsaw, as shown in **Figure 51**.

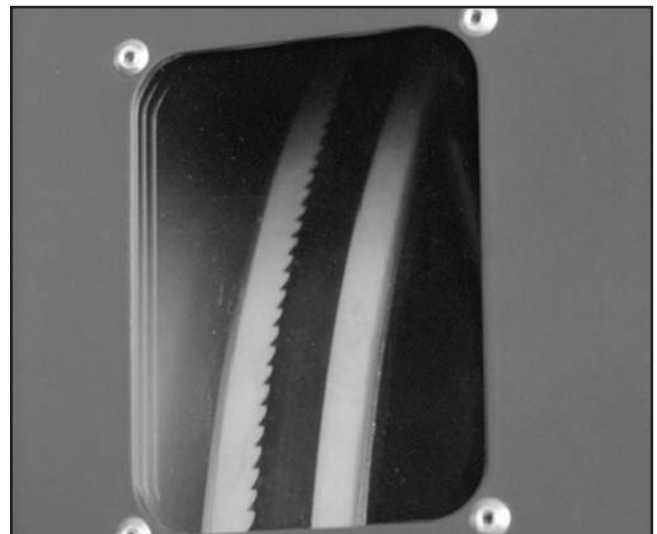


Figure 51. Blade tracking window.

3. Loosen the blade tracking lock lever.
4. Using the tracking controls (**Page 32, Figure 45**), adjust the blade so it tracks on the center of the wheel.
5. Tighten the blade tracking lock lever.



Ripping

Ripping is the process of cutting with the grain of the wood stock. For plywood and other processed wood, ripping simply means cutting down the length of the workpiece. For ripping, a wider blade is better. In most ripping applications, a standard raker tooth style will be sufficient (refer to **Blade information** on **Page 39**).

To make a rip cut:

1. Adjust the fence to match the width of the cut on your workpiece and lock the fence in place.
2. Adjust the blade guide assembly to the correct height.
3. After all safety precautions have been met, turn the bandsaw **ON**. Slowly feed the workpiece into the blade and continue with the cut until the blade is completely through the workpiece. **Figure 52** shows a typical ripping operation. **Note:** *If you are cutting narrow pieces, use a push stick to protect your fingers.*

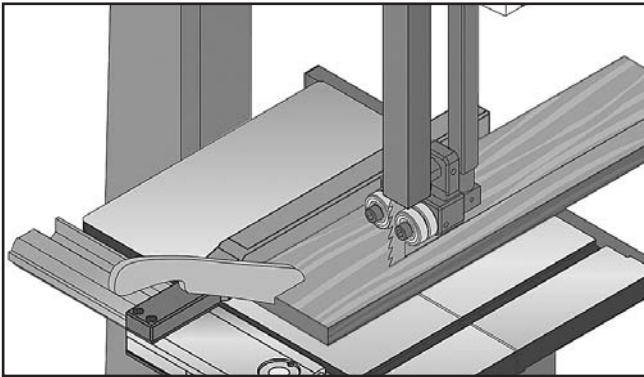


Figure 52. Example of typical ripping operation with a push stick.

⚠WARNING

NEVER place fingers or hands in the line of cut. In the event that something unexpected happens, your hands or fingers may slip into the blade. **ALWAYS** use a push stick when ripping narrow pieces. Failure to follow these warnings may result in serious personal injury!

Crosscutting

Crosscutting is the process of cutting across the grain of wood. For plywood and other processed wood, crosscutting simply means cutting across the width of the material.

To make a 90° crosscut:

1. Mark the workpiece on the edge where you want to begin the cut.
2. Adjust the blade guide assembly to the correct height and make sure the miter gauge is set to 0° (or other angle for angled cuts).
3. Move the fence out of the way. Place the workpiece evenly against the miter gauge.
4. Hold the workpiece against the miter gauge and line up the mark with the blade.
5. After all safety precautions have been met, turn the bandsaw **ON**. Slowly feed the workpiece into the blade and continue the cut until the blade is all the way through the workpiece. **Figure 53** shows a typical crosscutting operation.

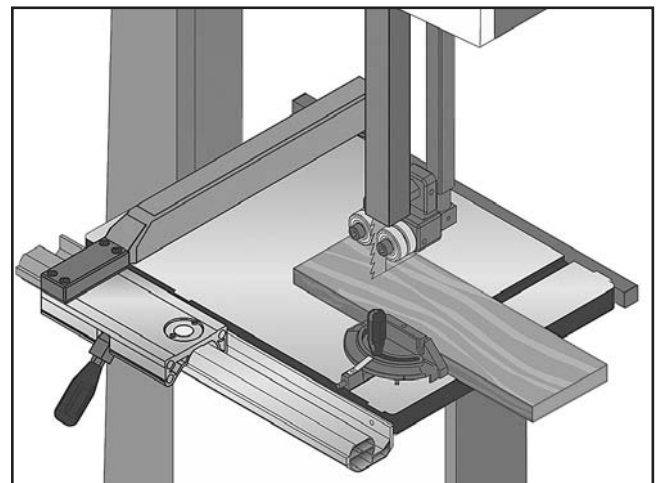


Figure 53. Example of crosscutting operation with miter gauge.



Resawing

"Resawing" (Figure 54) is cutting a workpiece into two or more thinner workpieces. Use the widest blade possible when resawing—a wide blade cuts straighter and is less prone to blade lead (see Page 42). For most applications, use a blade with a hook- or skip-tooth style. Choose blades with fewer teeth-per-inch (from 3 to 6), because they offer larger gullet capacities for clearing sawdust, reducing heat buildup and reducing strain on the motor.



Figure 54. Example of resawing lumber.

!WARNING

When resawing thin pieces, a wandering blade (blade lead) can tear through the surface of the workpiece, exposing your hands to the blade teeth. Always use push blocks when resawing and keep your hands clear of the blade.

To resaw a workpiece:

1. Verify that the bandsaw is set up properly and that the fence is parallel to the blade.
2. Install the resaw fence, set it to the desired width of cut, and lock it in place.
3. Adjust the upper blade guide so it is $\frac{1}{4}$ "–1" above the workpiece with a minimum amount of blade exposed.

NOTICE

The scale on the front rail will NOT be accurate when using the resaw fence.

4. Support the ends of the board if necessary.
5. Turn the bandsaw **ON**.
6. Using push paddles and a push stick, keep pressure against the fence and table, and slowly feed the workpiece into the moving blade until the blade is completely through (see Figure 54).

Cutting Curves

When cutting curves, simultaneously feed and turn the stock carefully so that the blade follows the layout line without twisting. Use either a narrower blade or a blade with more TPI (teeth per inch), or make more relief cuts, to avoid having to back the workpiece away from the blade, especially if the curve is sharp.

Always make short cuts first, then proceed to the longer cuts. Relief cuts will also reduce the chance that the blade will be pinched or twisted. Relief cuts are cuts made through the waste portion of the workpiece and are stopped at the layout line. As you cut along the layout line, waste wood is released from the workpiece, alleviating any pressure on the back of the blade. Relief cuts also make backing the workpiece out easier once the saw blade has come to a stop, if needed.

NOTICE

The list below displays blade widths and the corresponding minimum radii for those blade widths.

| Width | Radius |
|------------------|------------------|
| $\frac{1}{8}$ " | $\frac{1}{8}$ " |
| $\frac{3}{16}$ " | $\frac{3}{8}$ " |
| $\frac{1}{4}$ " | $\frac{5}{8}$ " |
| $\frac{3}{8}$ " | $1\frac{1}{4}$ " |
| $\frac{1}{2}$ " | $2\frac{1}{2}$ " |
| $\frac{5}{8}$ " | $3\frac{3}{4}$ " |
| $\frac{3}{4}$ " | $5\frac{1}{2}$ " |



Stacked Cuts

One of the benefits of a bandsaw is its ability to cut multiple copies of a particular shape by stacking a number of workpieces together. Before making stacked cuts, ensure that both the table and the blade are properly adjusted to 90° (see **Page 17**). Otherwise, any error will be compounded.

To complete a stacked cut:

1. Align your pieces from top to bottom to ensure that each piece has adequate scrap to provide a clean, unhampered cut.
2. Secure all the pieces together in a manner that will not interfere with the cutting. Hot glue on the edges works well, as do brad nails through the waste portion. (Be careful not to cut into the brads or you may break the blade!)
3. On the face of the top piece, lay out the shape you intend to cut.
4. Make relief cuts perpendicular to the outline of your intended shape in areas where changes in blade direction could strain the woodgrain or cause the blade kerf to bind.
5. Cut the stack of pieces as though you were cutting a single piece. Follow your layout line with the blade kerf on the waste side of your line (see **Figure 55**).

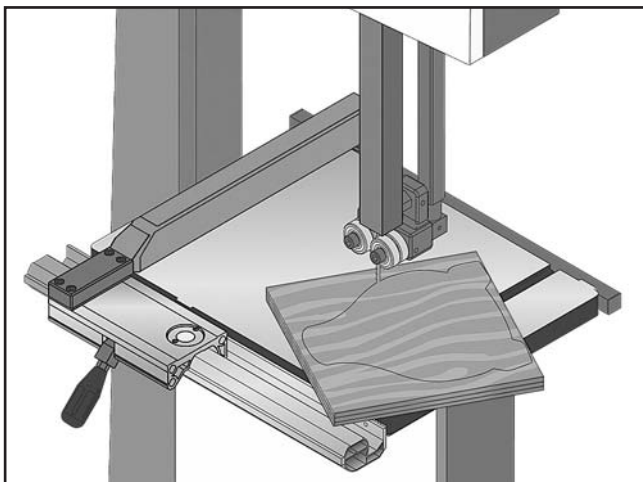


Figure 55. Typical stacked cut.

Blade Information

Selecting the right blade requires a knowledge of the various blade characteristics to match the blade with the particular cutting operation.

Blade Length

Measured by the circumference, blade lengths are usually unique to the brand of your bandsaw and the distance between wheels. This saw uses 166"–168" long blades. Refer to **Page 43** for blade replacements.

Blade Width

Measured from the back of the blade to the tip of the blade tooth (the widest point), blade width is often the first consideration given to blade selection. Blade width dictates the largest and smallest curve that can be cut, as well as how accurately it can cut a straight line.

This saw uses blades from $\frac{3}{8}$ " to $1\frac{3}{8}$ " in width. Always pick the size of blade that best suits your application.

- **Curve Cutting:** Use the chart in **Figure 56** to determine the correct blade for curve cutting. Determine the smallest radius curve that will be cut on your workpiece and use the corresponding blade width.

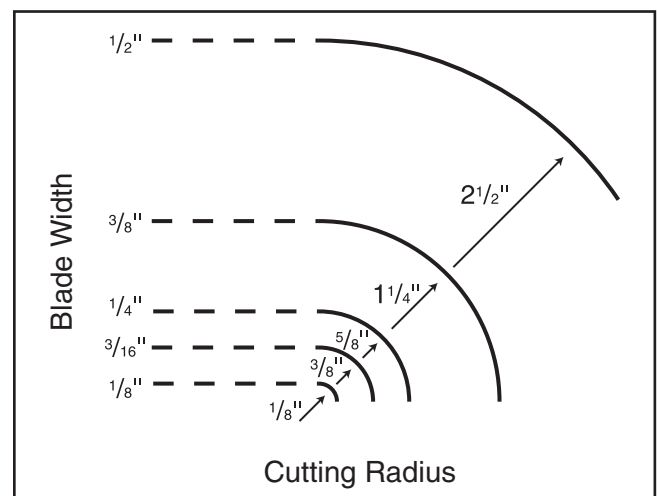


Figure 56. Blade width radii.



- **Straight Cutting:** Use the largest width blade that you own. Large blades excel at cutting straight lines and are less prone to wander.

Tooth Style

Figure 57 illustrates the three main tooth styles:

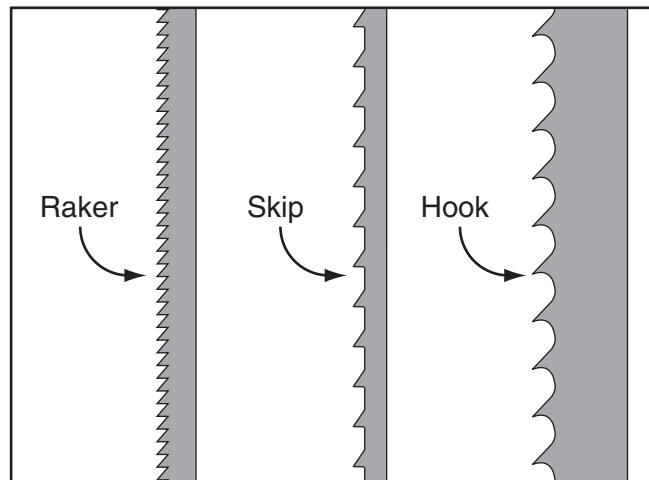


Figure 57. Raker, skip and hook tooth styles.

- **Raker:** Considered to be the standard because the tooth size and shape are the same as the tooth gullet. The teeth on raker blades usually are very numerous, have no angle, and produce cuts by scraping the material. As a result, smooth cuts can be achieved without cutting fast or generating more heat than other types while cutting.
- **Skip:** Similar to a raker blade that is missing every other tooth. Because of the design, skip toothed blades have a much larger gullet than raker blades, and therefore, cut faster and generate less heat. However, these blades also leave a rougher cut than raker blades.
- **Hook:** The teeth have a positive angle (downward) which makes them dig into the material, and the gullets are usually rounded for easier waste removal. These blades are excellent for the tough demands of resawing and ripping thick material.

Tooth Pitch

Measured as TPI (teeth per inch), tooth pitch determines the size of the teeth. More teeth per inch (fine pitch) will cut slower, but smoother; while fewer teeth per inch (coarse pitch) will cut rougher, but faster. As a general rule, choose blades that will have at least three teeth in the material at all times. Use fine-pitched blades on harder woods and coarse-pitched blades on softer woods.

Blade Care

A bandsaw blade is a thin piece of steel that is subjected to tremendous strain. You can obtain longer use from a bandsaw blade if you give it fair treatment and always use the appropriate feed rate for your operation. Be sure to select blades with the proper width, style, and pitch for each application. The wrong choice of blades will often produce unnecessary heat which will shorten the life of your blade.

A clean blade will perform much better than a dirty blade. Dirty or gummed up blades pass through the cutting material with much more resistance than clean blades. This extra resistance also causes unnecessary heat. Resin/pitch cleaners are excellent for cleaning dirty blades.

Blade Breakage

Many conditions may cause a bandsaw blade to break. Blade breakage is unavoidable, in some cases, since it is the natural result of the peculiar stresses that bandsaw blades are subjected to. Blade breakage is also due to avoidable circumstances. Avoidable breakage is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or support guides.

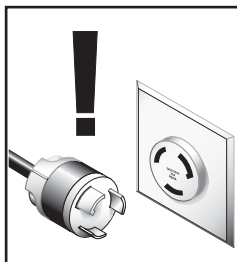
The most common causes of blade breakage are:

- Faulty alignment/adjustment of the guides.
- Forcing/twisting a wide blade around a short radius.
- Feeding the workpiece too fast.
- Dull teeth or damaged tooth set.
- Over-tensioned blade.
- Top blade guide assembly set too high above the workpiece.



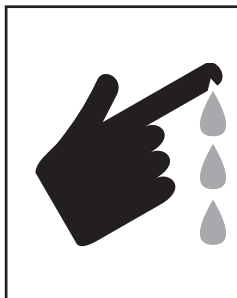
- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running the bandsaw when not in use.
- Leaving blade tensioned when not in use.
- Using the wrong TPI for the workpiece thickness. (The general rule of thumb is three teeth in the workpiece at all times.)

Blade Changes



WARNING

Always disconnect power to the machine when changing blades. Failure to do this may result in serious personal injury.



CAUTION

All saw blades are dangerous and may cause personal injury. To reduce the risk of being injured, wear leather gloves when handling saw blades.

Removing a Blade

1. DISCONNECT BANDSAW FROM POWER!
2. Release the blade tension.
3. Remove the table insert and the table pin. Adjust the upper and lower guide bearings as far away as possible from the blade.
4. Open the both wheel covers, and with gloved hands, slide the blade off of both wheels.
5. Slide the blade through the slot in the table.

Replacing a Blade

1. Slide the blade through the table slot, ensuring that the teeth are pointing forward and down toward the table. **Note:** *If the teeth will not point downward in any orientation, the blade is inside-out. Put on heavy gloves, remove the blade, and twist it right side-out.*
2. Slip the blade through the guides, and mount it on the upper and lower wheels (**Figure 58**).

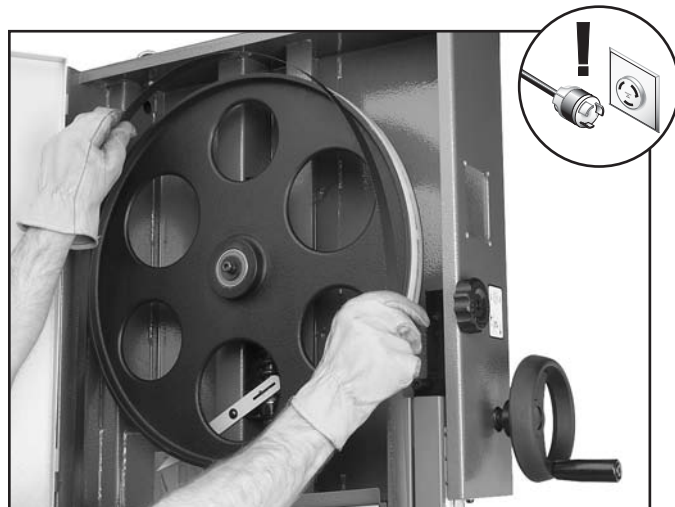


Figure 58. Typical example of placing blade on the wheels.

3. Adjust tension as described on **Page 22**.
4. Adjust tracking if needed (see **Page 16**).
5. Align the upper and lower support and guide bearings (see **Page 26**), then adjust the blade guide bearings (see **Page 29**).
6. Replace the table insert and table pin.
7. Close the wheel covers.

NOTICE

When you change the blade or adjust the tension and tracking, the spaces between the guide and support bearings will change. In these cases, you must adjust the upper and lower guide and support bearings before continuing with cutting operations (**Pages 26 & 29**).



Blade Lead

Bandsaw blades may wander off the cut line when sawing, as shown in **Figure 59**. This is called blade lead. Blade lead is usually caused by too fast of a feed rate, a dull or abused blade, or improper tension. If your blade is sharp/undamaged and you still have blade lead, perform the following procedures.

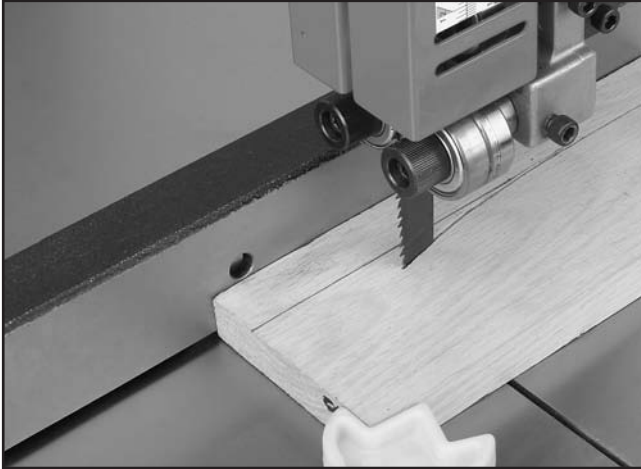


Figure 59. Example of blade leading away from line of cut.

Correcting Blade Lead

1. Use less pressure when feeding the workpiece through the cut.
2. Check that the miter slot or fence is parallel to the blade line, and correct if necessary (See **Aligning Table, Page 25** and **Aligning Fence, Page 25**).
3. Check for proper blade tension. If the blade tension is correct and it is not convenient to replace the blade, compensate for lead by skewing the fence or shifting the table.

To skew your fence:

1. Cut a piece of scrap wood approximately $\frac{3}{4}$ " thick x 3" wide x 17" long. On a wide face of the board, draw a straight line parallel to the long edge.

2. Slide the bandsaw fence out of the way and cut halfway through the board on the line by pushing it into the blade. Turn the bandsaw **OFF** and wait for the blade to stop.
3. Clamp the board to the bandsaw table without moving it. Now slide the fence over to the board so it barely touches one end of the board.
4. Loosen the three cap screws that secure the fence rail to the underside of the table (see **Page 25**).
5. Skew the fence so it is parallel to the edge of the scrap piece.
6. While maintaining the skew, tighten the cap screws loosened in **Step 4**.
7. Make a few cuts using the fence. If the fence still does not seem parallel to the blade, repeat **Steps 1–6** until the blade and fence are parallel with each other.

To shift the table:

1. On a scrap piece of wood, mark a line that is perpendicular to the front edge.
2. Cut halfway through the board on the line by pushing it into the blade.
3. Turn the bandsaw **OFF** and wait for the blade to stop.
4. Loosen the four cap screws that mount the table to the trunnion. Shift the table to compensate for the blade lead, then retighten the cap screws.
5. Repeat **Steps 1–4** until the blade cuts straight.



SECTION 5: ACCESSORIES

Replacement Blades

These replacement blades are milled for exact tooth set and are made with high quality tool steel.

168" Timber Wolf® Replacement Blades for the Model G0701.

| MODEL | WIDTH | TPI |
|-------|--------|------------|
| H9575 | 1/2" | 3 POS CLAW |
| H9576 | 1/2" | 4 POS CLAW |
| H9577 | 1/2" | 6 POS CLAW |
| H9578 | 1/2" | 10 RAKER |
| H9579 | 1" | 3 POS CLAW |
| H9580 | 1" | 4 POS CLAW |
| H9581 | 1" | 10 RAKER |
| H9582 | 1 1/4" | 3/4" PITCH |

G1928—Bandsaw Handbook

This is the bandsaw bible. Covers step-by-step instructions for basic/advanced cutting techniques. Also includes advanced maintenance, service and troubleshooting procedures, as well as information on bandsaw history/design and blade metallurgy. 320 pages.

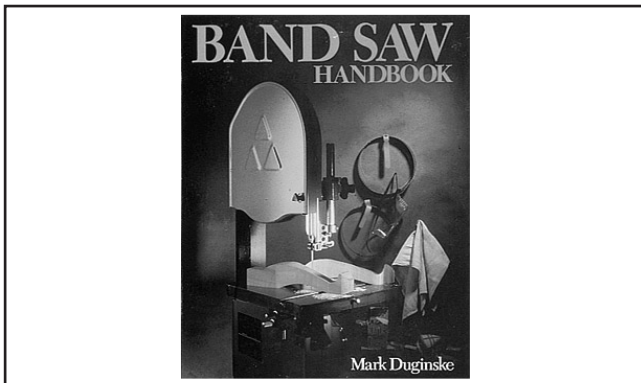


Figure 60. Bandsaw handbook.

Call 1-800-523-4777 To Order

T10117—Big Mouth Dust Hood with Stand

Capture dust from any machine operation with this Big Mouth Dust Hood. Simply attach a 4" dust collection hose and adjust the hood right where you need it. The free standing base eliminates complicated machine set-ups and the tilting 16³/₈" x 12⁷/₈" hood adjusts from 23" to 43" high. Every shop needs one of these!



Figure 61. T10117 Big Mouth Dust Hood.

G7315Z—Super Heavy-Duty SHOP FOX® Mobile Base

This patented, super heavy-duty mobile machine base is the strongest mobile base on the market. 18" x 24¹/₂" minimum and adjusts to 28¹/₂" x 33¹/₂". Maximum 1200 lb. capacity. This base is extremely stable with outrigger type supports and a four wheel system. Weighs 38 lbs.



Figure 62. G7315Z SHOP FOX® Mobile Base.



- T20501—Face Shield Crown Protector 4"
- T20502—Face Shield Crown Protector 7"
- T20503—Face Shield Window
- T20452—"Kirova" Anti-Reflective S. Glasses
- T20451—"Kirova" Clear Safety Glasses
- H0736—Shop Fox® Safety Glasses
- H7194—Bifocal Safety Glasses 1.5
- H7195—Bifocal Safety Glasses 2.0
- H7196—Bifocal Safety Glasses 2.5



Figure 63. Eye protection assortment.

- H4978—Deluxe Earmuffs - 27dB
 - H4979—Twin Cup Hearing Protector - 29dB
 - T20446—Ear Plugs 200 Pair - 31dB
- Protect your hearing before its too late. Especially important if you or employees operate for hours at a time.



Figure 64. Hearing protection assortment.

- H2499—Small Half-Mask Respirator
 - H3631—Medium Half-Mask Respirator
 - H3632—Large Half-Mask Respirator
 - H3635—Cartridge Filter Pair P100
- Wood dust has been linked to nasal cancer and severe respiratory illnesses. If you work around dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!



Figure 65. Half-mask respirator with disposable cartridge filters.

- G5562—SLIPIT® 1 Qt. Gel
- G5563—SLIPIT® 12 Oz. Spray
- G2871—Boeshield® T-9 12 Oz. Spray
- G2870—Boeshield® T-9 4 Oz. Spray
- H3788—G96® Gun Treatment 12 Oz. Spray
- H3789—G96® Gun Treatment 4.5 Oz. Spray



Figure 66. Recommended products for protecting unpainted cast iron/steel on machinery.

Call 1-800-523-4777 To Order



SECTION 6: MAINTENANCE



Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily

- Check/correct loose mounting bolts.
- Check/correct damaged saw blade.
- Check/correct worn or damaged wires.
- Correct any other unsafe condition.

Monthly

- Check for V-belt tension, damage, or wear.
- Remove blade and thoroughly clean all built-up sawdust from the rubber tires on the wheels.
- Clean/vacuum dust buildup from inside cabinet and off motor.

Cleaning

Cleaning the Model G0701 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin-dissolving cleaner to remove it. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.

Unpainted Cast Iron

Protect the unpainted cast iron surfaces on the table and fence by wiping them clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.

Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Section 5: Accessories** on **Page 44** for more details).

Brushes

The bandsaw is equipped with two lower brushes. The brushes should be checked daily and cleaned when they become dirty. There are adjustment brackets that allow the brushes to be adjusted for bristle wear. Refer to **Adjusting Wheel and Brushes** on **Page 55** for adjustment details.

Lubrication

Since all bearings are sealed and permanently lubricated, simply leave them alone until they need to be replaced. Do not lubricate them.

This machine does need lubrication in other places. An essential part of lubrication is cleaning the components before lubricating them.

This step is critical because dust and chips build up on lubricated components, which makes them hard to move. Simply adding more grease to built-up grime will not result in smooth moving parts.

Clean the components in this section with mineral spirits or an oil/grease solvent cleaner.



Blade Guide Rack and Pinion

| Lubricant | Frequency | Qty |
|--------------------------|-----------|-----------|
| Multi-purpose GL2 Grease | As Needed | Thin Coat |

To lubricate the blade guide rack and pinion:

1. Lower the upper blade guide until it reaches the table.
2. DISCONNECT BANDSAW FROM POWER!
3. Using a rag and mineral spirits, wipe off any existing grease and sawdust buildup on the rack (see **Figure 67**).



Figure 67. Example of rack lubrication location.

4. Apply a thin coat of multi-purpose GL2 grease to the rack.
5. Re-connect the machine to power, then move the blade guide up and down several times to distribute the lubricant.
6. Lower the blade guide to the table, disconnect the bandsaw from power, then remove any excess grease from the rack to help prevent sawdust buildup.

Tension Adjustment Assembly

| Lubricant | Frequency | Qty |
|--------------------------|-----------|-----------|
| Multi-purpose GL2 Grease | As Needed | Thin Coat |

To lubricate the tension adjustment assembly:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the top wheel cover and look through the top of the wheel.
3. Using a rag and mineral spirits, wipe off any existing grease and sawdust buildup on the blade tension adjustment assembly and tension lever cam.
4. Apply a thin coat of multi-purpose GL2 grease to the tension adjustment assembly and tension lever cam (see **Figure 68**).

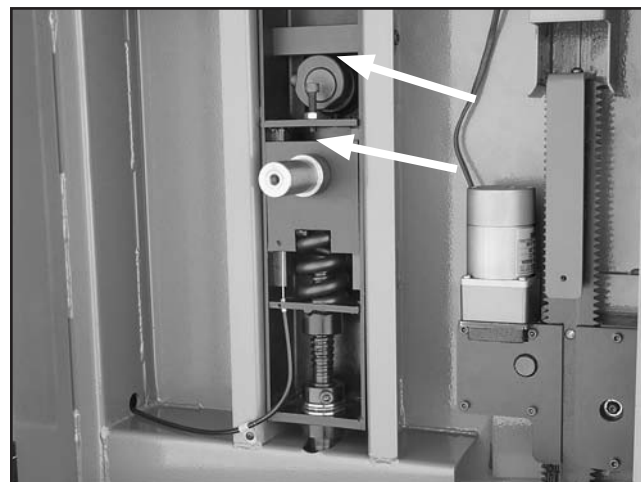


Figure 68. Tension adjustment assembly locations (top wheel removed for clarity).



Table Tilt Rack and Pinion Assembly

| Lubricant | Frequency | Qty |
|--------------------------|-----------|-----------|
| Multi-purpose GL2 Grease | As Needed | Thin Coat |

To lubricate the table tilt rack and pinion assembly:

1. DISCONNECT BANDSAW FROM POWER!
2. With the table perpendicular to the blade, and using a rag and mineral spirits, wipe off all existing grease and sawdust buildup from the rack.
3. Move the table up to its maximum 45° angle and wipe off all existing grease and sawdust buildup from the rack (**Figure 69**).



Figure 69. Lubricating table tilt rack and pinion assembly.

4. Apply a thin coat of multi-purpose GL2 grease to the rack.
5. Move the table up and down several times to distribute the grease, then wipe off any excess grease.

Trunnion

| Lubricant | Frequency | Qty |
|--------------------------|-----------|-----------|
| Multi-purpose GL2 Grease | As Needed | Thin Coat |

To lubricate the trunnion:

1. DISCONNECT BANDSAW FROM POWER!
2. Move the table up until it reaches its maximum 45° angle, then use a rag and mineral spirits to wipe off all excess grease and sawdust from the trunnion.
3. Apply a thin coat of multi-purpose GL2 grease to the outside surfaces of the trunnion (**Figure 70**).

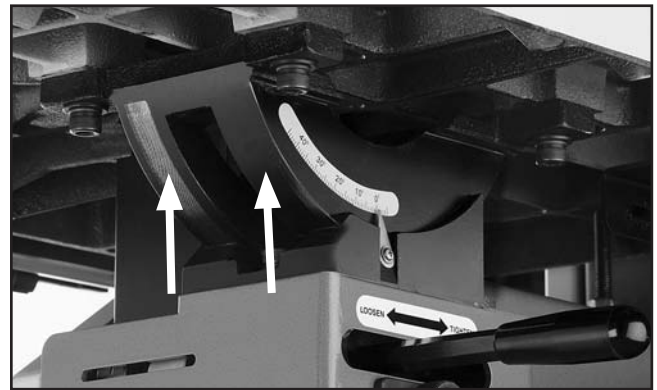


Figure 70. Trunnion lubrication location.

4. Move the table down and then back up to distribute the grease, then wipe off any excess grease from the trunnion.



Redressing Rubber Tires

As the bandsaw ages, the rubber tires may need to be redressed if they become hardened or glazed over. Redressing the rubber tires improves blade tracking and reduces vibration/blade lead.

If the rubber tires become too worn, then blade tracking will become extremely difficult. At that point, redressing will no longer be effective and the tires must be replaced.

To redress the rubber tires:

1. DISCONNECT BANDSAW FROM POWER!
2. Put on heavy leather gloves.
3. Remove the blade.
4. Clean any built-up sawdust from the rubber tires.
5. Hold 100 grit sandpaper against the rubber tire and rotate the wheel by hand. Only redress the rubber enough to expose a fresh rubber surface.
6. Re-install the blade, then check blade tension (refer to **Page 22**) and tracking (refer to **Page 16**).



SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting



| Symptom | Possible Cause | Possible Solution |
|---|--|--|
| Machine does not start or a breaker trips. | <ol style="list-style-type: none"> 1. Emergency OFF button engaged/at fault. 2. Key switch turned to "0" position. 3. Upper wheel cover safety switch disengaged/at fault. 4. Brake switch at fault. 5. Thermal overload relay in mag switch tripped. 6. Break or short in wiring; or loose or corroded connections. 7. Plug or receptacle is corroded or mis-wired. 8. Power supply switched off/has incorrect voltage. 9. Motor connection wired incorrectly. 10. Contactor has poor contacts or is at fault. 11. Blown fuse/tripped circuit breaker. 12. Motor ON switch at fault. 13. Start capacitor has blown. 14. Centrifugal switch at fault. 15. Motor at fault. | <ol style="list-style-type: none"> 1. Rotate button to reset/replace button. 2. Turn key switch to "1" position. 3. Close upper wheel cover or adjust/replace switch. 4. Re-adjust/test/replace brake switch. 5. Allow relay/motor to cool. If necessary, press reset button inside switch. 6. Trace/replace broken or corroded wires; fix loose connections. 7. Correct the wiring. 8. Switch power supply on/verify voltage. 9. Wire motor correctly. Refer to inside junction box cover or Page 65. 10. Test all legs for power, test field coil, and fix contacts or replace if at fault. 11. Replace/reset fuse or circuit breaker. Repair possible short or circuit overload. 12. Replace switch. 13. Test/replace if at fault. 14. Adjust/replace centrifugal switch. 15. Test for shorted windings or bad bearings; repair or replace. |
| Main motor chatters during startup or during operation. | <ol style="list-style-type: none"> 1. Power supply has incorrect voltage on one or more legs. | <ol style="list-style-type: none"> 1. Contact electrician to check incoming voltage. |



| Symptom | Possible Cause | Possible Solution |
|---|---|---|
| Machine has excessive vibration or noise. | <ol style="list-style-type: none"> 1. V-belt tension incorrect. 2. Bent, dull, or damaged blade. 3. Loose blade. 4. Blade weld contacting support bearing or blade guides. 5. Loose machine component. 6. Machine incorrectly mounted on floor. 7. Motor fan rubbing on fan cover. 8. V-belt worn or damaged. 9. Wheels not coplanar. 10. V-belt has a high spot. 11. Centrifugal switch out of adjustment; at fault. 12. Pulley loose or not in alignment; shaft bent. 13. Worn wheel bearing. 14. Wheel tires worn or incorrectly installed. 15. Wheels out of balance. 16. Motor bearings worn or damaged. | <ol style="list-style-type: none"> 1. Tighten V-belt. See Page 53. 2. Replace blade (Page 41). 3. Tighten blade. 4. Use file or stone to smooth and round the back of the blade. 5. Tighten loose component. 6. Level/shim base; tighten/adjust mounting hardware or feet. 7. Fix/replace fan cover; replace loose or damaged fan. 8. Replace V-belt (use link belts if possible). See Page 54. 9. Adjust wheels to be coplanar (Page 60). 10. Replace/adjust the V-belt (Page 54). 11. Adjust/replace centrifugal switch. 12. Replace worn pulley, key, and shaft, and realign. 13. Check/replace wheel bearing. 14. Replace or re-install wheels. 15. Replace wheels. 16. Replace motor bearings or replace motor. |
| Machine stalls or slows when operating. | <ol style="list-style-type: none"> 1. Too much pressure when feeding workpiece. 2. Workpiece too moist or material not suitable for machine. 3. Workpiece is warped. 4. Fence incorrectly adjusted. 5. V-Belt(s) slipping. 6. Run capacitor at fault. 7. Motor connection wired incorrectly. 8. Motor overheated. 9. Contactor has poor contacts or is at fault. 10. Centrifugal switch at fault. 11. Main motor at fault. | <ol style="list-style-type: none"> 1. Reduce pressure when feeding workpiece. 2. Only cut wood and ensure workpiece moisture is below 20%. 3. Straighten workpiece or use a different one. 4. Adjust/calibrate fence. 5. Tension/replace belt(s); ensure pulleys are aligned. 6. Test/repair/replace. 7. Review wiring diagram on motor cover; correct wire connections. 8. Let cool, clean motor, and reduce workload. 9. Test all legs for power, test field coil, and fix contacts or replace if at fault. 10. Adjust/replace centrifugal switch if available. 11. Test for shorted windings, bad bearings and repair or replace. |
| Guide post moves slower than normal, travel is sporadic, or stops completely. | <ol style="list-style-type: none"> 1. Guide post motor at fault. | <ol style="list-style-type: none"> 1. Replace guide post motor (Page 58). |
| Miter bar binds in miter slot. | <ol style="list-style-type: none"> 1. Miter slot dirty or gummed up. | <ol style="list-style-type: none"> 1. Carefully clean miter slot. |
| Table does not tilt to 0 degrees. | <ol style="list-style-type: none"> 1. Pointer or scale calibrated incorrectly. 2. Positive stop bolt not set correctly. | <ol style="list-style-type: none"> 1. Calibrate pointer/scale at true 0 degrees (Page 26). 2. Adjust positive stop bolt. |
| Table does not tilt to 45 degrees. | <ol style="list-style-type: none"> 1. Pointer or scale calibrated incorrectly. 2. Machine component blocking path. | <ol style="list-style-type: none"> 1. Calibrate pointer/scale at true 45 degrees. 2. Remove component blocking table. |



| Symptom | Possible Cause | Possible Solution |
|--|---|--|
| Table hard to tilt. | <ol style="list-style-type: none"> 1. Sawdust or pitch trapped between trunnion and base. 2. Metal burrs on trunnion. | <ol style="list-style-type: none"> 1. Clean trunnion. 2. Remove burrs. |
| The cuts are rough, or show scoring. | <ol style="list-style-type: none"> 1. Blade is overloaded and twisting. 2. The blade TPI is too coarse. 3. The blade is loose and slipping on wheels. 4. Blade tracking is incorrect. 5. The blade has missing or bent teeth. 6. The blade has a faulty weld. | <ol style="list-style-type: none"> 1. Decrease the feed rate. 2. Use the correct blade for material and speed of cut. 3. Adjust bade tension as required. 4. Adjust the blade tracking back to normal. 5. Replace the blade (Page 41). 6. Replace the blade (Page 41). |
| Blade or teeth break. | <ol style="list-style-type: none"> 1. Blade tension is incorrect. 2. Incorrect blade for application. 3. The feed is too heavy or blade speed is too slow. 4. Cutting corners too sharply. 5. Blade used when dull. 6. Blade tracking is wrong. 7. Blade guide adjustment at fault. 8. Inadequate blade support. 9. Blade weld at fault. 10. Wheel tires worn or incorrectly installed. 11. Fence or miter slot out of alignment with blade. | <ol style="list-style-type: none"> 1. Adjust blade tension (Page 22). 2. Use correct blade for application. 3. Reduce feed rate or adjust blade speed (Page 33). 4. Use a wider arc on outside cuts, or use relief cuts to make tight inside cuts. 5. Replace the blade (Page 41). 6. Adjust the blade tracking back to normal (Page 16). 7. Adjust blade guide bearings for correct blade support. 8. Adjust upper blade guides as close as possible to workpiece. 9. Replace with a new blade (Page 41). 10. Replace or re-install wheels. 11. Align table miter slot and fence with blade (Page 25). |
| Blade wears on one side, slows, smokes or shows overheating. | <ol style="list-style-type: none"> 1. Blade contacting table insert. 2. The blade guides are worn or mis-adjusted. 3. The blade has insufficient support. 4. Blade is installed backwards. 5. Too much side pressure when feeding workpiece. 6. The wheels are out of alignment. 7. Dull or incorrect blade. 8. Blade is deformed. 9. Fence not parallel with blade (pressure at blade backside). 10. Table top surface is not parallel or square to blade. | <ol style="list-style-type: none"> 1. Adjust blade guide bearings to eliminate excess side pressure. Adjust table for correct blade clearance and miter slot alignment. 2. Adjust or replace the blade guides. 3. Adjust the blade guide support bearings correctly. 4. Check blade direction as described in "Replacing Blade" on Page 41 and reverse blade if necessary. 5. Feed workpiece straight into the blade. 6. Adjust the wheels so they are coplanar (Page 60). 7. Replace blade (Page 41). 8. Install new blade. 9. Adjust fence parallel with blade (Page 25). 10. Adjust/shim table/trunnion position until blade and table are parallel and square. |
| Sawdust buildup inside cabinet. | <ol style="list-style-type: none"> 1. Clogged dust port. 2. Low CFM (airflow) from dust collection system. | <ol style="list-style-type: none"> 1. Clean out dust port. 2. Repair ducting for leaks or clogs, move dust collector closer to machine, install a stronger dust collector. |



| Symptom | Possible Cause | Possible Solution |
|--|---|--|
| Blade tracks incorrectly, or comes off wheels. | <ol style="list-style-type: none"> 1. Tracking is not adjusted properly. 2. Wheels are not coplanar. 3. Blade tension is too loose. 4. Blade guides need adjustment. 5. Feeding workpiece too fast. 6. Incorrect blade for bandsaw. 7. Blade is deformed, worn or dull. 8. Rubber tire on wheel is damaged or worn. | <ol style="list-style-type: none"> 1. Adjust tracking (Page 16). 2. Adjust wheel coplanarity (Page 60). 3. Increase blade tension (Page 22). 4. Align and adjust blade guides (Pages 26-29). 5. Feed workpiece slower (Page 33). 6. Install correct blade for machine. 7. Install new blade, and de-tension blade when not in use. 8. Replace wheels. |
| The cut is crooked, or the blade wanders (blade lead). | <ol style="list-style-type: none"> 1. The feed pressure is too high or the blade speed is too slow. 2. The blade tension is low. 3. The blade is dull or damaged. 4. Inadequate blade support. 5. Incorrect blade for application. 6. The blade tracking is wrong. 7. Table is loose. 8. Fence or miter slot out of alignment with blade. 9. Blade guide alignment at fault. | <ol style="list-style-type: none"> 1. Adjust feed rate and cutting speed as required. 2. Increase the blade tension (Page 22). 3. Replace the blade (Page 41). 4. Adjust upper blade guide so it is as close as possible to workpiece (Page 36). 5. Use wider blade. 6. Adjust the blade tracking back to normal. 7. Tighten table trunnion mounting bolts or tilt lock lever. 8. Align table miter slot and fence with blade. 9. Adjust blade guide bearings for correct blade support. |



Checking and Tensioning V-Belts

To ensure optimum power transmission from the motor to the blade, the V-belts must be in good condition and operate under proper tension. The belts should be checked for cracks, fraying, and wear. Belt tension should be checked at least every 3 months—more often if the bandsaw is used daily.

| Tools Needed: | Qty |
|---------------------|-----|
| Ruler | 1 |
| Hex Wrench 6mm..... | 1 |
| Wrench 17mm..... | 1 |
| 2x4s 14" | 2 |

Checking V-Belts

1. DISCONNECT BANDSAW FROM POWER!
2. Open the wheel covers.
3. Note the condition of the V-belts. If the V-belts are cracked, frayed, or glazed, they should be replaced.
4. Push the center of the V-belts. Note the amount of deflection (**Figure 71**). If deflection is more than $\frac{1}{8}$ ", tension the V-belt.

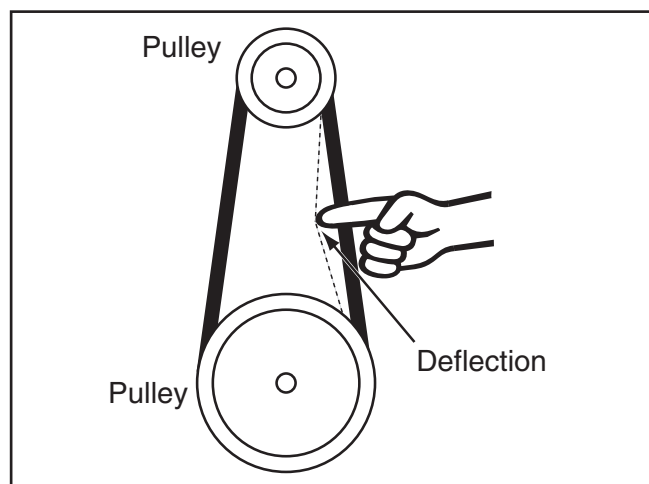


Figure 71. V-belt deflection.

Tensioning V-Belts

1. DISCONNECT BANDSAW FROM POWER!
2. Open the wheel covers.
3. Loosen the motor adjustment screws shown in **Figure 72**.

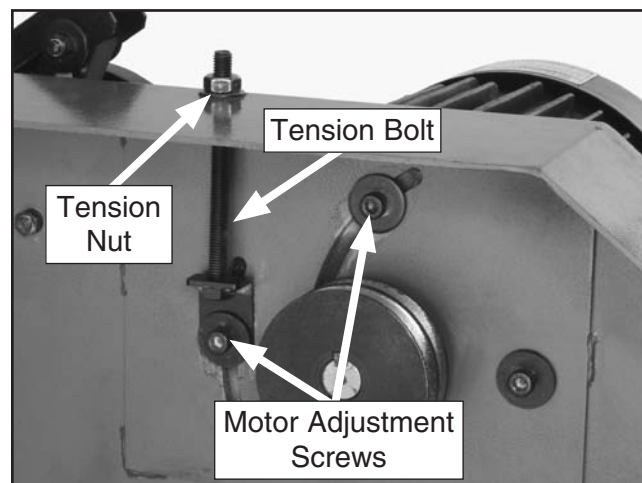


Figure 72. Motor mount bolts and tension bolt (lower wheel removed for clarity).

4. Adjust the V-belt tension:
 - If the belt is too loose, turn the tension nut clockwise to tighten the belts.
 - If the V-belt is too tight, turn the tension nut counterclockwise to loosen the belts.
- Note:** The V-belt tension is correct when there is approximately $\frac{1}{8}$ " deflection between the pulleys when moderate pressure is applied with your hand.
6. When the V-belt tension is correct, tighten the motor adjustment screws, and close the wheel covers.



Replacing V-Belts

1. Follow **Steps 1-3** in **Checking V-Belts** on **Page 53**.
2. Open the wheel covers, then remove the bandsaw blade (refer to **Blade Changes** on **Page 41**).
3. Loosen the motor adjustment screws shown in **Figure 72** on **Page 53**, then turn the tension nut counterclockwise.
4. Roll the old V-belts off of the motor pulley.
5. Remove the wheel cap screw and flat washer shown in **Figure 73**, then slide the lower wheel out and set it on a flat surface.



Figure 73. Wheel cap screw for removing the wheel.

6. Remove the old V-belts from the lower wheel pulley.
7. Inspect the brake shoe.
—If the brake pad thickness measures 1mm or less, then it needs to be replaced. Follow the instructions in **Replacing Brake Shoe** on **Page 59** to replace it.

8. Place the new V-belts onto the lower wheel pulley.
9. Slide the wheel all the way towards the back of the machine, then secure it with the cap screw and flat washer removed in **Step 5**.

CAUTION

In the next step you must be extremely careful while rolling the belts onto the pulley. Your fingers could be pinched between the pulley and belts if you are not careful.

10. Roll the new V-belts onto the motor pulley.

Note: *Replace both V-belts as a matched set.*

11. Tension the V-belts (see **Tensioning V-Belts** on **Page 53**), then tighten the motor adjustment screws.
12. Re-install the blade, adjust blade tension (refer to **Page 22**) and tracking (refer to **Page 16**), then close the wheel covers.



Adjusting Wheel and Blade Brushes

The lower wheel compartment contains the brushes shown in **Figure 74**. These brushes are designed to sweep sawdust off the wheel tire and blade as the bandsaw is operating. To work properly, the brushes must make contact with the wheel and blade.

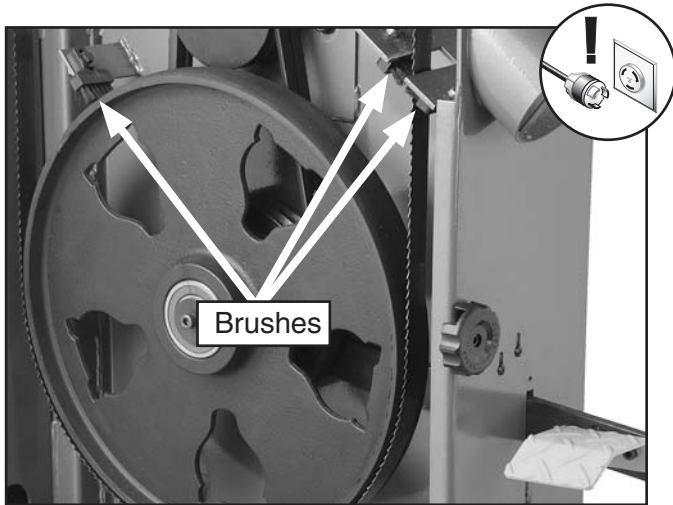


Figure 74. The wheel brush and blade brushes.

Tools Needed: Qty
Wrench/Socket 10mm2

To adjust the brushes:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the upper and lower wheel covers.
3. Loosen the bolt/nut that secures each brush in place.
4. Adjust each brush so it makes good contact with the wheel or blade—without bending the bristles.
5. Tighten the bolt/nuts to secure each brush in place.

Adjusting Tension Lever

The quick release tension lever is set up correctly for use with the pre-installed 168" blade. However, if you install a different length blade, you will need to adjust the tension lever adjustment screw so the quick release tension lever works correctly.

Tools Needed: Qty
Hex Wrench 6mm..... 1
Wrench 13mm 2

To adjust the tension lever:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the wheel covers.
3. Loosen the jam nut (see **Figure 75**), then remove the screw and nut.

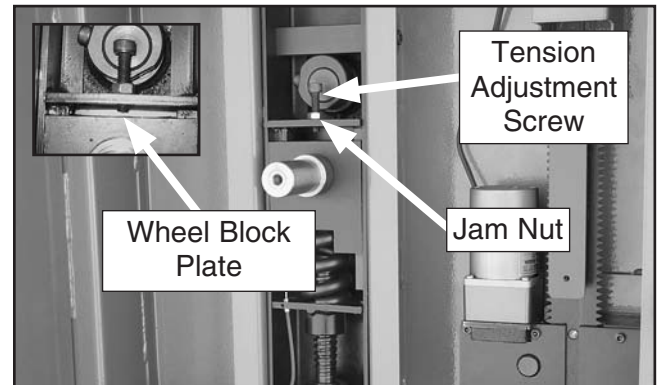


Figure 75. Quick release tension lever adjustment screw.

4. Put the quick release tension lever in the engaged position (all the way to the right), then turn the blade tension handwheel until the blade tension matches the mark on the blade tension scale for the appropriate blade width.
5. Thread the cap screw with the jam nut through the plate where it was attached previously and down until it contacts the wheel block plate, then back the screw off two full turns (see **Figure 75**).
6. Tighten the jam nut.



Adjusting Guide Post Travel

The guide post assembly should remain parallel with the blade front-to-back and side-to-side along its length of travel. If it does not, follow these instructions to correctly adjust the guide post.

Tools Needed:

| | |
|--------------------------|-------------|
| Machinist's Square | 1 |
| Small Ruler | 1 |
| Hex Wrench 5mm..... | 1 |
| Hex Wrench 6mm..... | 1 |
| Wrench 10mm | 1 |
| Metal Shims..... | (As Needed) |

Checking/Adjusting Guide Post Parallel Side-to-Side With Blade

1. Loosen the guide post lock knob, raise the guide post and lock it in place.
2. DISCONNECT BANDSAW FROM POWER!
3. Tighten the blade to the tension that will be used during operation.
4. Place a machinist's square on the table next to the side of the blade as illustrated in **Figure 76**.

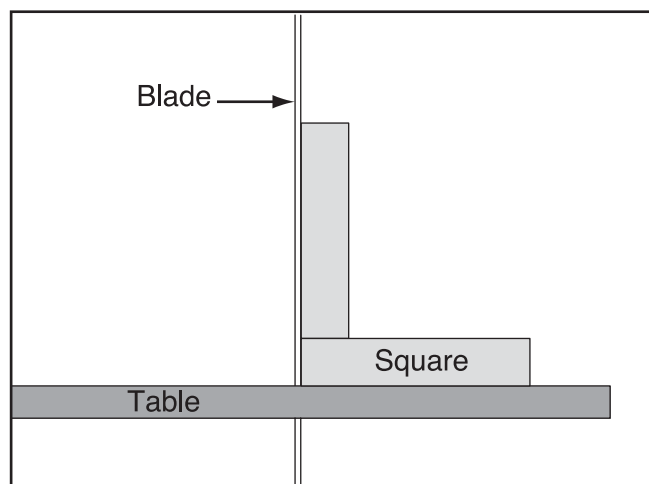


Figure 76. Squaring table to blade.

5. Adjust the table square to the blade using the table tilt handwheel, then secure it with the table tilt lock handle.

6. Re-connect the machine to power, and lower the guide post to within 1" of the table top, tighten the guide post lock knob to hold it in place.
7. Disconnect the machine from power, then place a machinist's square on the table next to the right hand side of the guide post, as shown in **Figure 77**.

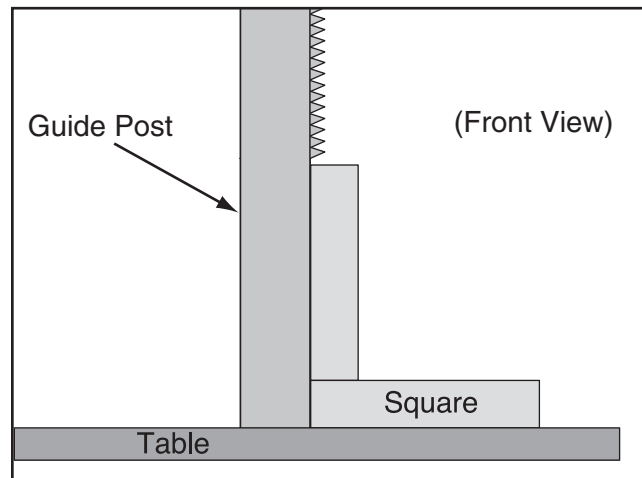


Figure 77. Example of checking guide post squareness.

—If there is no gap between the square and the guide post along its full length, no adjustments need to be made. Proceed to "To check/adjust if the guide post is parallel with the blade front-to-back."

—If there is a gap between the square and the guide post, the guide post is not parallel with the blade. Go to **Step 7**.

8. Loosen each of the four screws shown in **Figure 78** ¼ turn.

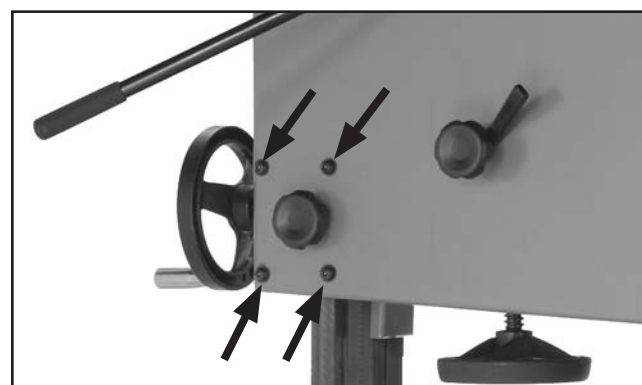


Figure 78. Guide post adjustment screws.



9. Gently tap the lower part of the guide post in the appropriate direction until there is no gap between the square and the guide post.
10. Tighten the screws shown in **Figure 78**, and verify that the guide post stays parallel with the blade along its full path of movement. If necessary, repeat this entire procedure until it is.

Checking/Adjusting Guide Post Parallel with Blade Front-to-Back

1. DISCONNECT BANDSAW FROM POWER!
2. Remove the blade.
3. Place one hand under the upper blade guide assembly to keep it from falling, loosen the two cap screws that secure the guide assembly to the guide post (**Figure 79**), then remove the guide assembly.

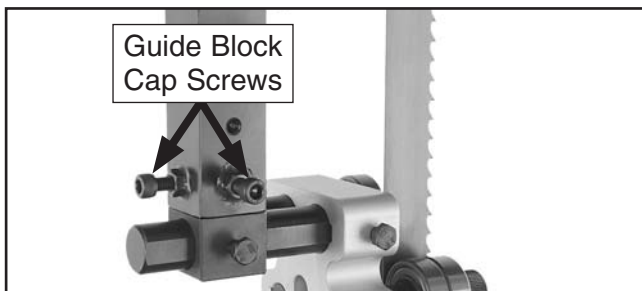


Figure 79. Guide block cap screws (blade guard removed for photo clarity).

4. Remove the two cap screws and hex bolt that secure the upper blade guard to the guide post, then remove the blade guard.
5. Re-install the blade and re-tension it.
6. Loosen the guide post lock knob, lower the guide post to within 1" of the table top, then tighten the lock knob.
7. Measure the distance "A" between the top front face of the guide post rack and the back of the blade (see **Figure 80**).

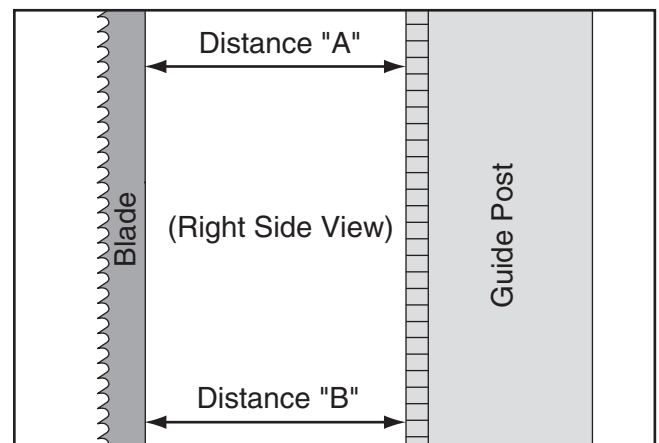


Figure 80. Example of measuring distance between rack and blade at top of guide post.

8. Measure the distance "B" between the bottom front face of the guide post rack and the back of the blade (see **Figure 80**).
 - If the measurements taken in **Steps 7–8** are equal, no adjustments need to be made. Go to **Step 11**.
 - If the measurements taken in **Steps 7–8** are not equal, go to **Step 9**.
9. Loosen the four screws shown in **Figure 78** enough to fit metal shims (wide enough to fit the full width of the guide bracket), between the frame and the guide post bracket (see **Figure 81**).

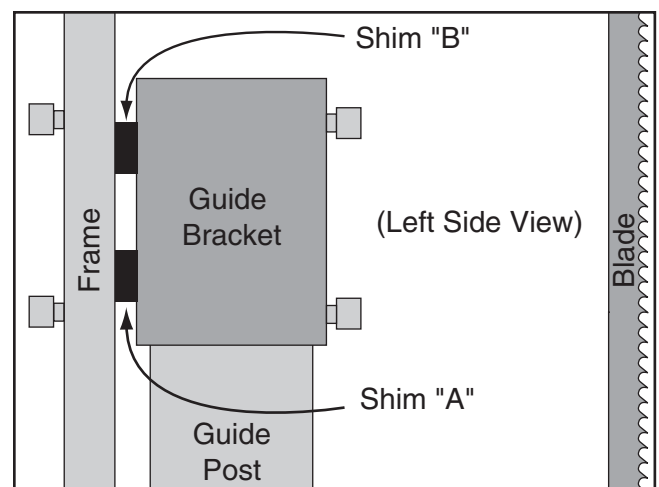


Figure 81. Location for placing shims. (Shim thickness not drawn to scale.)



—If the guide post-to-blade distance is greater at the bottom than at the top, place a shim between the bottom of the bracket and the frame (Shim "A"). This will tilt the bottom of the guide post toward the blade.

—If the guide post-to-blade distance is less at the bottom than at the top, place a shim between the top of the bracket and the frame (Shim "B"). This will tilt the bottom of the guide post away from the blade.

10. Tighten the four screws shown in **Figure 78**, then repeat **Steps 7–8**.

11. Remove the blade.

12. Re-install the blade guard with the two cap screws and hex bolt you removed in **Step 4**.

Tip: *It may help to install the lower part of the guard first with the cap screws, then install the hex bolt. Also, when the guide post assembly is raised up there is limited room to access the hole where the hex bolt threads in. So, try installing the hex bolt with the guide post assembly closer to the table.*

13. Re-install the blade guide assembly.

14. Re-install the blade and the table pin, then close the wheel covers.

15. Check the blade tension (refer to **Page 22**) and tracking (refer to **Page 16**).

16. Perform the **Aligning Blade Bearings** and **Adjusting Blade Guide Bearings** procedures on **Pages 26** and **29**.

Replacing Guide Post Motor

If the guide post motor ever needs to be replaced, contact our Technical Support Department at (570) 546-9663 to order the replacement guide post motor Part P0701405 (refer to **Page 76**).

| Tools Needed | Qty |
|--------------------------------|-----|
| Phillips Head Screwdriver..... | 1 |

To replace the guide post motor:

1. DISCONNECT BANDSAW FROM POWER!
2. Remove the blade guard from the guide post.
3. Remove the blade and upper wheel.
4. Remove the Phillips head screws that secure the motor to the gear box (see **Figure 82**).

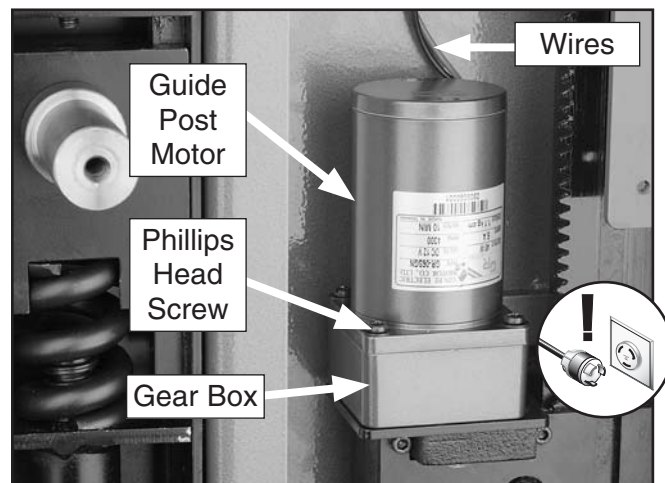


Figure 82. Location of guide post motor.

5. Disconnect the guide post motor wires from the wires inside the upper frame, making sure you secure these to the bandsaw temporarily to avoid the possibility of them dropping into the frame.



6. Mount the new motor to the gearbox with the screws you removed in **Step 3**, then connect the new guide post motor wires to the wires inside the frame.
7. Replace the upper wheel.
8. Re-install the upper blade guard.
9. Re-install, tension, and track the blade.

Replacing Brake Shoe

The brake shoe will need to be replaced when the thickness of the pad measures 1mm or less. The following are indications that the brake pad needs to be replaced: The bandsaw takes noticeably longer to stop when the foot brake is pushed or the foot brake makes metal-to-metal grinding sounds.

Contact our Technical Support Department at (570) 546-9663 to order the replacement brake shoe—Part P0636X036 (refer to **Page 69**).

Components and Hardware Needed:

Replacement Brake Shoe (Part P0636X036).... 1

Tools Needed:

Hex Wrench 5mm..... 1
 Hex Wrench 6mm..... 1
 Wrench 10mm 1
 Wrench 17mm..... 1

To replace the brake shoe:

1. DISCONNECT BANDSAW FROM POWER!
2. Follow **Steps 1-7** in **Replacing V-Belts** on **Page 54**.

3. Remove the cap screws, lock washers, and bushings that secure the brake shoe to the brake lever, then remove the brake shoe (see **Figure 83**).

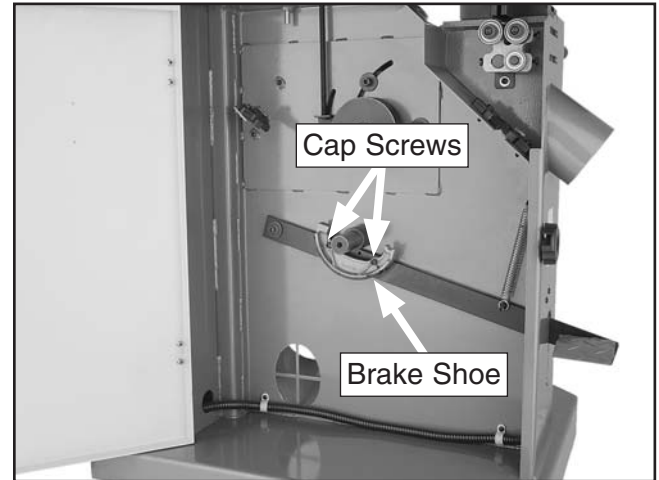


Figure 83. Brake shoe location.

4. Install a new brake shoe onto the brake lever with the cap screws, lock washers, and bushings removed in **Step 3**.
5. Reinstall the V-belts onto the pulleys, then slide the lower wheel back onto the bearing shaft.
6. Tension the V-belts (see **Tensioning V-Belts** on **Page 53**).
7. Reinstall, tension and track the blade, then adjust the upper and lower blade guides and support bearings as needed.
8. Close the wheel covers.



Aligning Wheels

Components and Hardware Needed: Qty
 70" Long 2x4 1

Tools Needed:

Hex Wrenches 5, 6, 8mm..... 1 Ea
 Wrenches, 10, 17mm..... 1
 Tape Measure..... 1
 Coplanarity Gauge (see **Figure 84**) 1
 Straightedge
 Fine Ruler..... 1

Wheel alignment is one of the most critical factors for optimal performance from your bandsaw.

Heat, vibration, wandering, blade wear, tire wear and overall bandsaw wear are considerably decreased when the wheels are properly aligned or “coplanar.”

Coplanar wheels automatically track the blade by balancing it on the crown of the wheel. This is known as coplanar tracking.

Checking Coplanarity

1. Make the "Coplanarity Gauge" shown in **Figure 84**.

Note: For best results, straighten the edges of the 2x4 with a jointer before cutting.

2. DISCONNECT BANDSAW FROM POWER!
3. Remove the fence and open both wheel covers.
4. Adjust the blade guides away from the blade, loosen blade tension, remove the table insert and pin, then remove the blade.
5. Remove the table.
6. Reinstall the blade (**Page 41**), making sure the guide bearings and support bearings are away from the blade, then tighten your blade to the tension that it will be used during operation.
7. Place your coplanarity gauge up against both wheels in the positions shown in **Figure 85**.

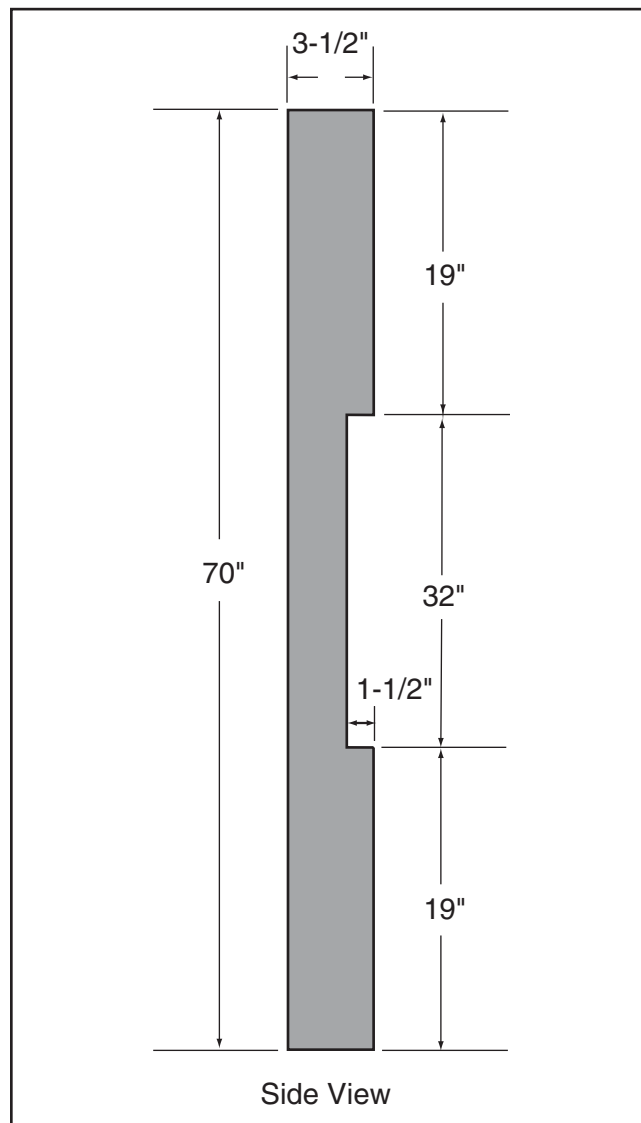


Figure 84. Dimensions of coplanarity gauge.

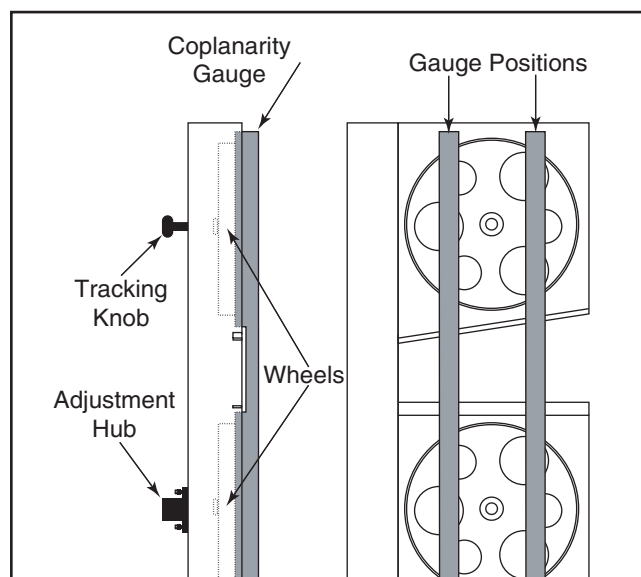


Figure 85. Checking for coplanarity.



—If the wheels are coplanar (**Figure 86, A**), the straightedge will evenly touch the top and bottom of both wheels.

—If the wheels are not coplanar (**Figure 86, B**), place the straightedge on the lower wheel first (ensuring that it touches both the top and bottom rim), then adjust the upper wheel tracking knob to make the upper wheel coplanar with the lower wheel.

—If the straightedge does not touch both wheels evenly, the lower wheel needs to be adjusted (**Figure 86, C**) or the upper wheel needs to be shimmed (**Figure 86, D**).

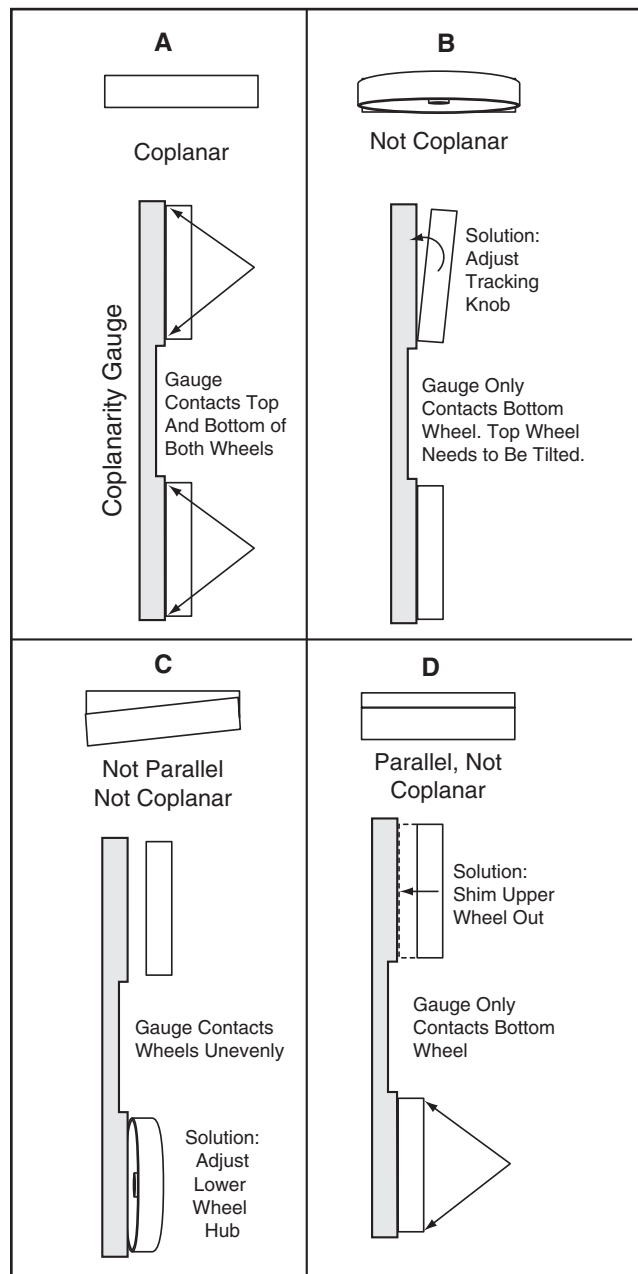


Figure 86. Coplanarity diagram.

Shimming Upper Wheel

1. DISCONNECT BANDSAW FROM POWER!
2. Make sure the top wheel is adjusted parallel with the bottom wheel.
3. With a straightedge touching both points of the lower wheel, measure the distance away from the upper wheel, which is out of adjustment (see **Figure 87**).
4. Remove the blade from the saw, then remove the upper wheel.
5. Determine how many shim washers you need to compensate for the distance measured in **Step 3** and place them on the wheel shaft.
6. Replace the upper wheel, the original washers, the securing screw, and the blade.
7. Tighten the blade, then check the wheels with the coplanarity gauge. (Wheel coplanarity changes as the blade is tightened, so it is best to check the wheel alignment when the blade is tensioned as it would be for normal operations.)
8. When the wheels are coplanar, place a mark on each wheel where you held the straightedge. This assures repeated accuracy every time you adjust your wheels.

Note: When wheels are properly coplanar, the blade may not be centered on the crown of the wheel, but it will be balanced.

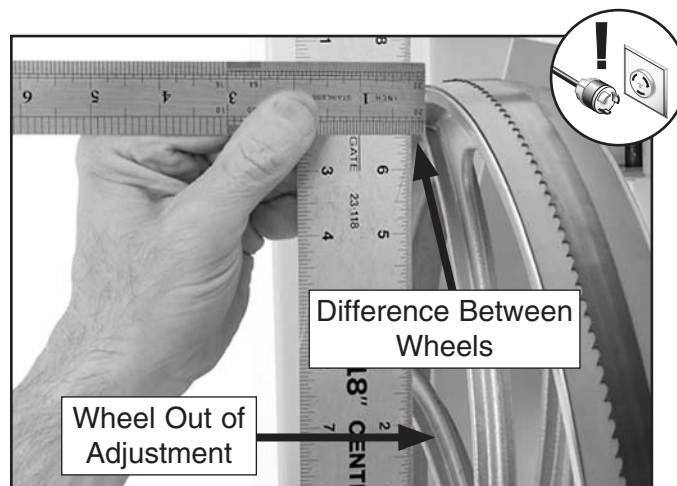


Figure 87. Determining distance needed to shim upper wheel.



Adjusting Lower Wheel

Only do this procedure if you cannot make the wheels coplanar with the tracking knob or by shimming the upper wheel. Make sure the upper wheel is adjusted as close as possible to being coplanar with the lower wheel before beginning. Do this procedure with the blade fully tensioned.

To adjust the lower wheel:

1. DISCONNECT BANDSAW FROM POWER!
2. Loosen the jam nuts on the lower wheel adjustment hub (see **Figure 88**).

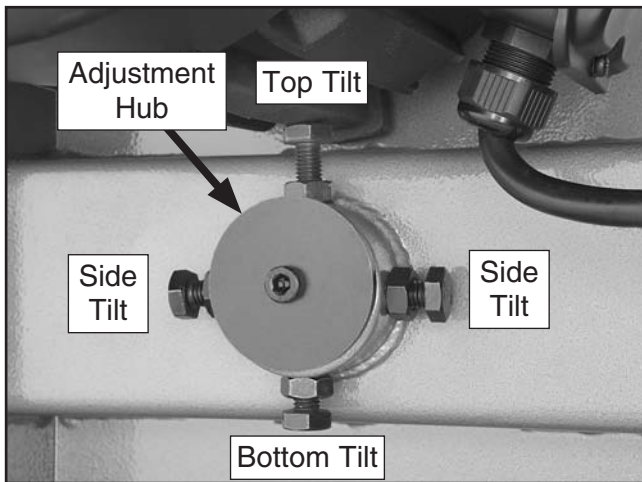


Figure 88. Lower wheel adjustment control.

3. Loosen one tilt adjustment hex bolt, then tighten the opposing hex bolt approximately an equal amount.
4. Check the wheels with the coplanarity gauge, then adjust the lower wheel at the hub as needed until it is parallel and coplanar with the top wheel.
5. Tighten the jam nuts to lock the tilt adjustment hex bolts in position.



SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Study this section carefully. If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine.

WARNING

Wiring Safety Instructions

SHOCK HAZARD. Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

MODIFICATIONS. Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved after-market parts.

WIRE CONNECTIONS. All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.
















CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

EXPERIENCING DIFFICULTIES. If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

NOTICE

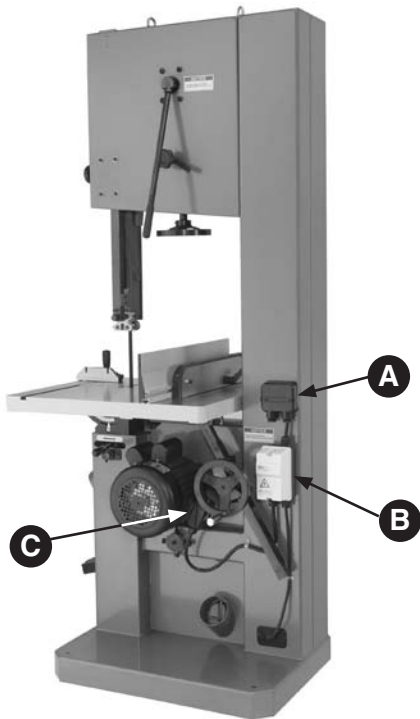
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

| | | | |
|---|--|--|--|
| BLACK  | BLUE  | YELLOW  | LIGHT BLUE  |
| WHITE  | BROWN  | YELLOW GREEN  | BLUE WHITE  |
| GREEN  | GRAY  | PURPLE  | TURQUOISE  |
| RED  | ORANGE  | PINK  | |

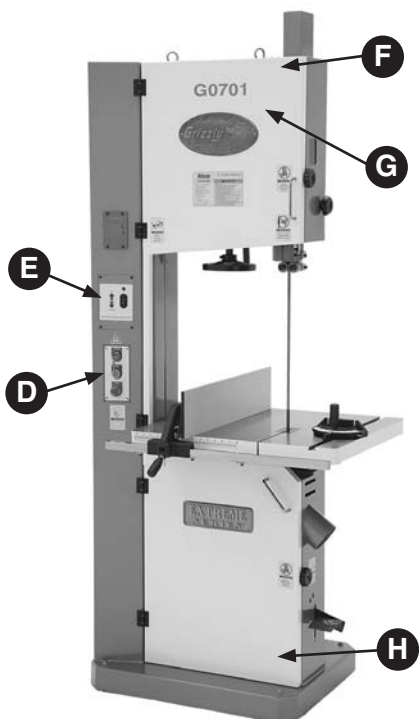


Electrical Overview

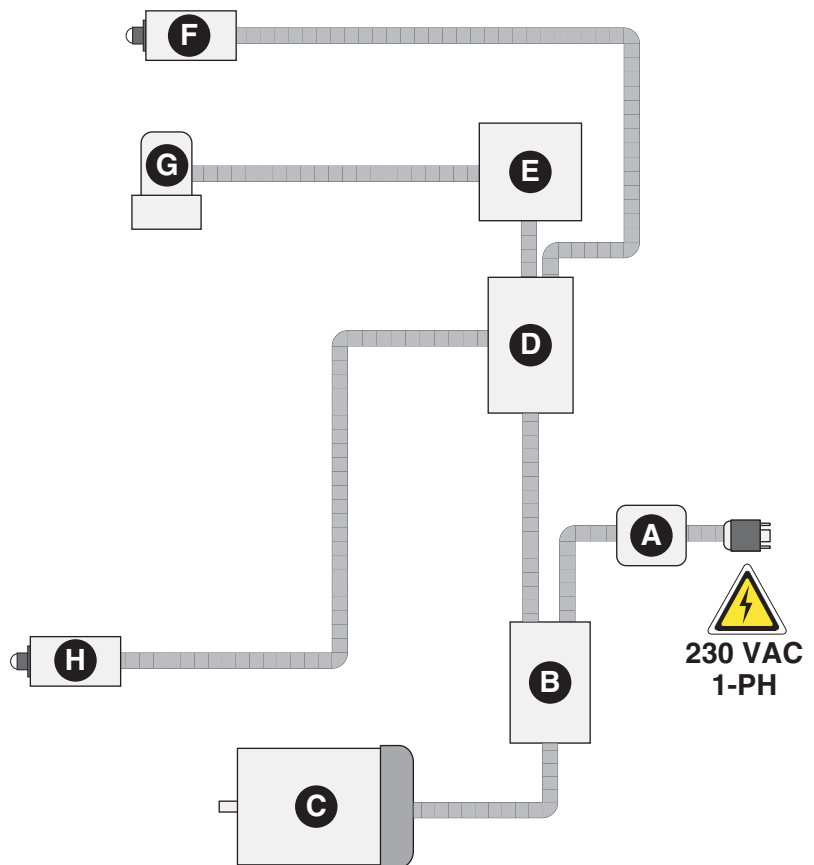


Rear View

| | Description | Wiring Diagram Page Reference |
|----------|------------------------------|-------------------------------|
| A | Power Junction Box | 65 |
| B | Magnetic Switch | 65 |
| C | Motor Junction Box | 65 |
| D | Control Panel | 66 |
| E | Guide Post Elevation Control | 66 |
| F | Upper Door Safety Switch | 67 |
| G | Guide Post Elevation Motor | 67 |
| H | Brake Switch | 67 |



Front View



Junction Box, Motor & Magnetic Switch



Figure 89. Power supply wiring.

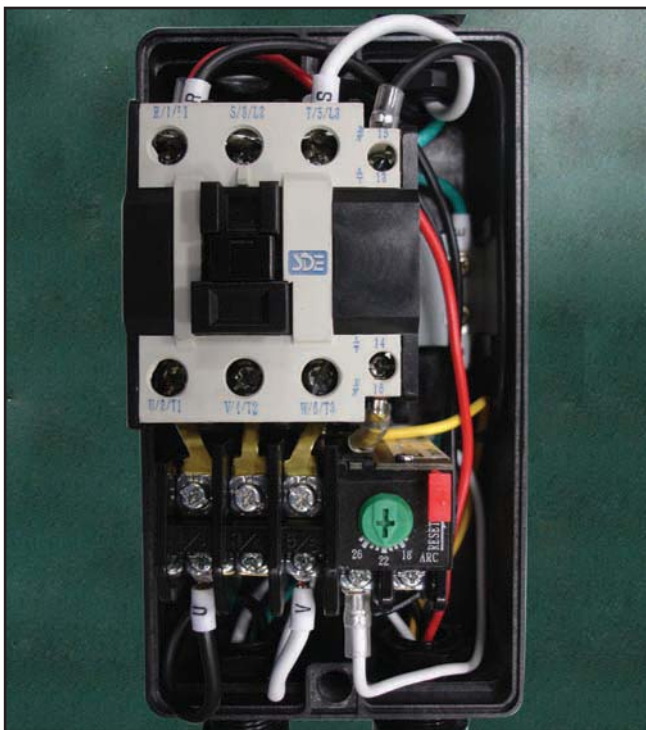
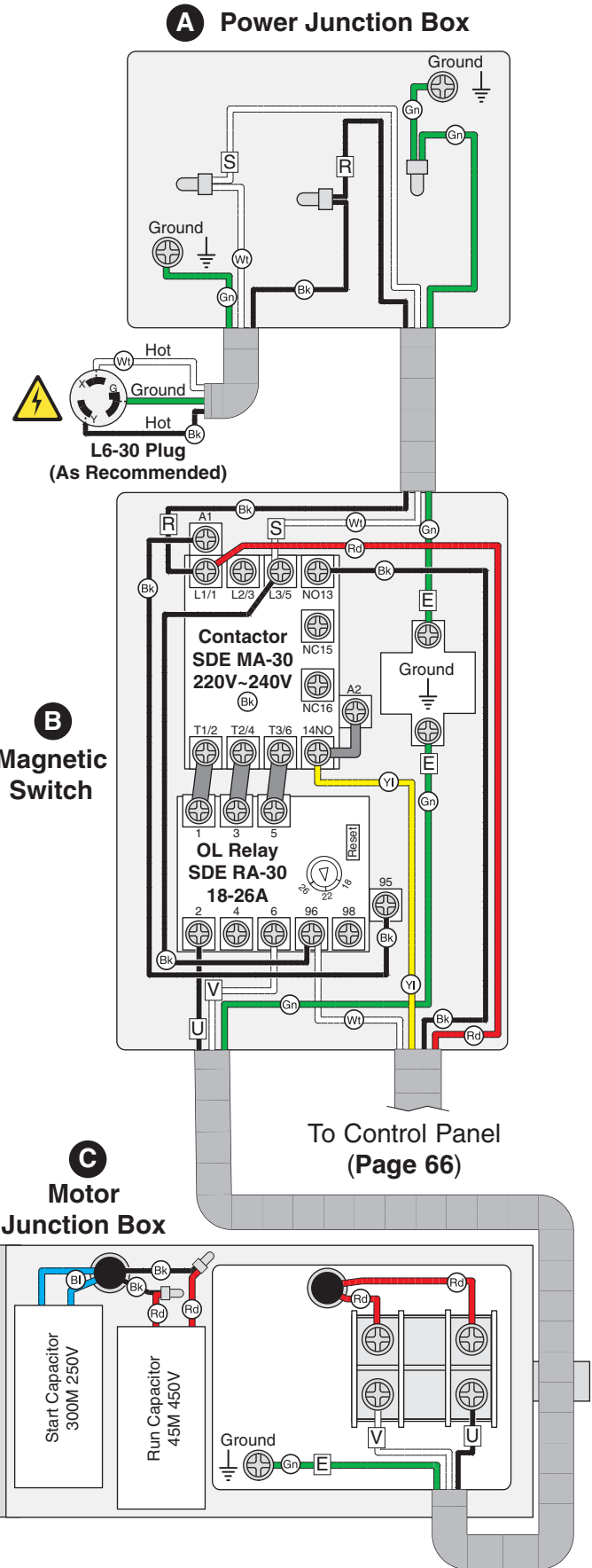


Figure 90. Magnetic switch wiring.



Figure 91. Motor junction box wiring.



Control Panel & Guide Post Control

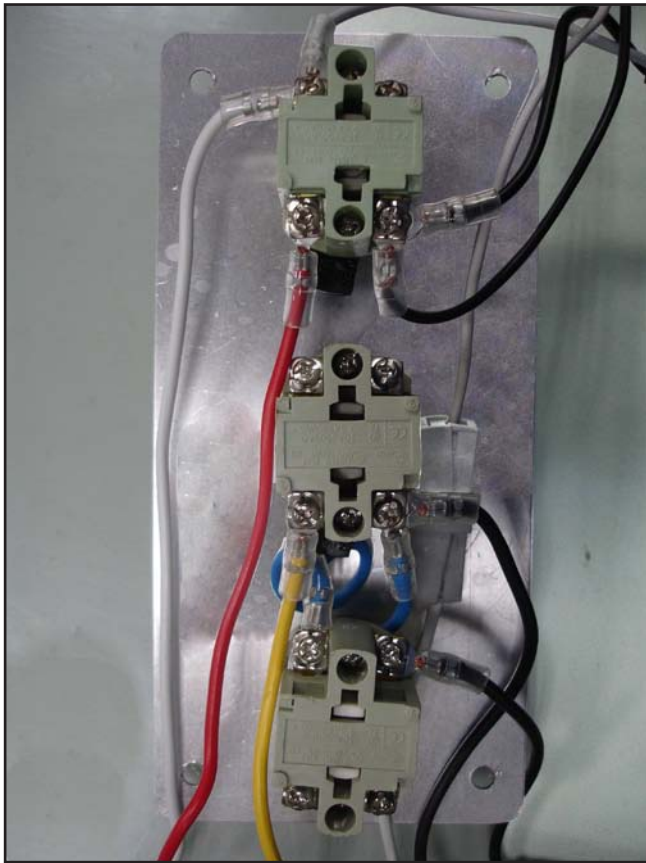


Figure 92. Control panel wiring.

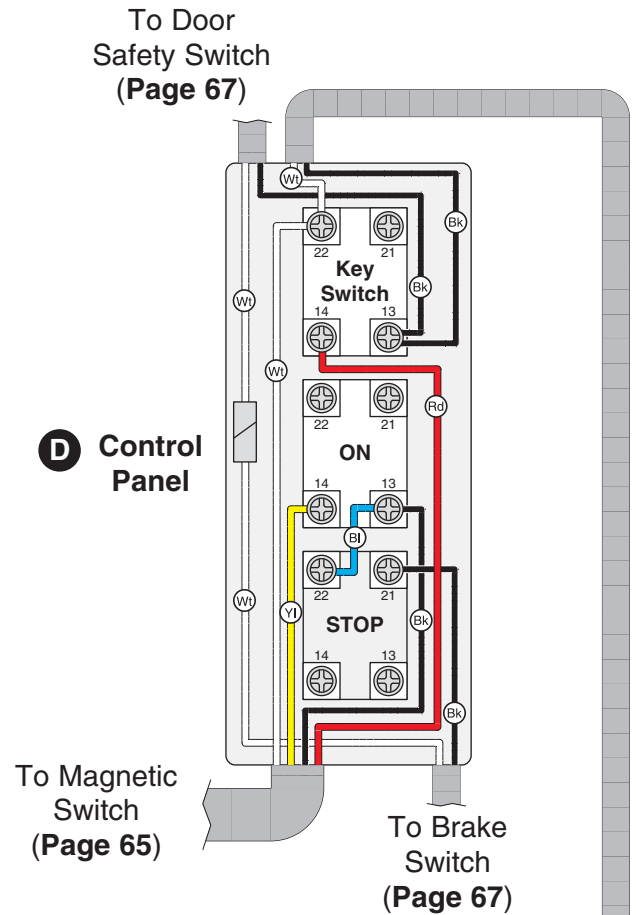
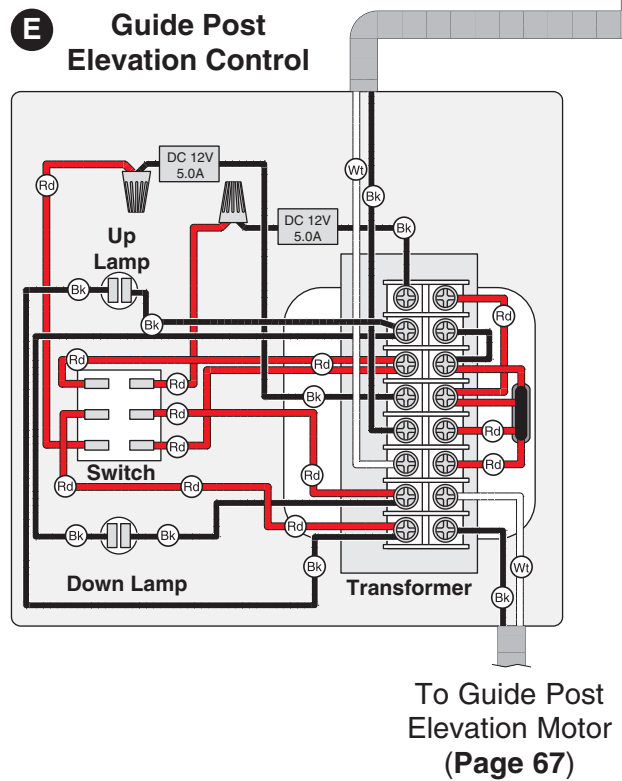


Figure 93. Guide post elevation control wiring.



Door Switch, Post Motor & Brake Switch

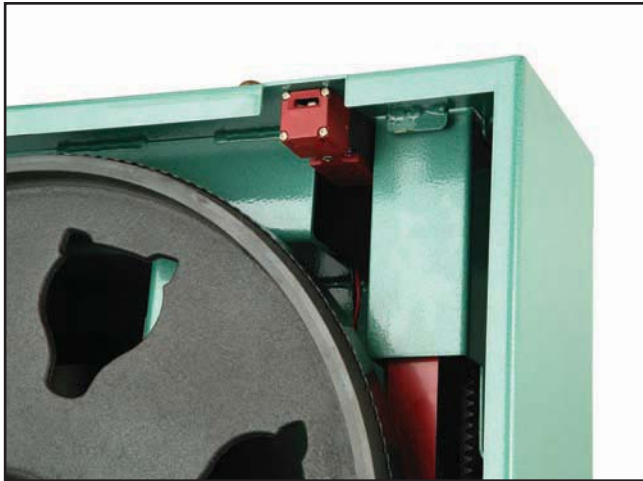


Figure 94. Upper door safety switch wiring.

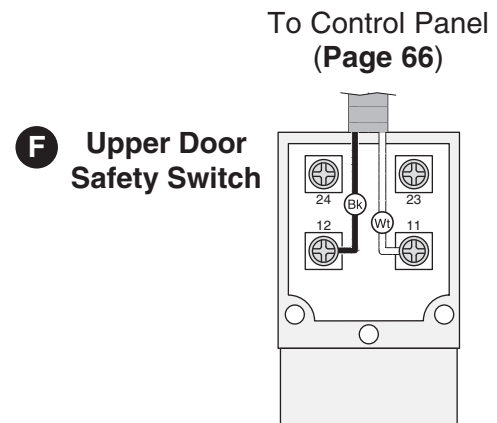


Figure 95. Guide post elevation motor wiring.

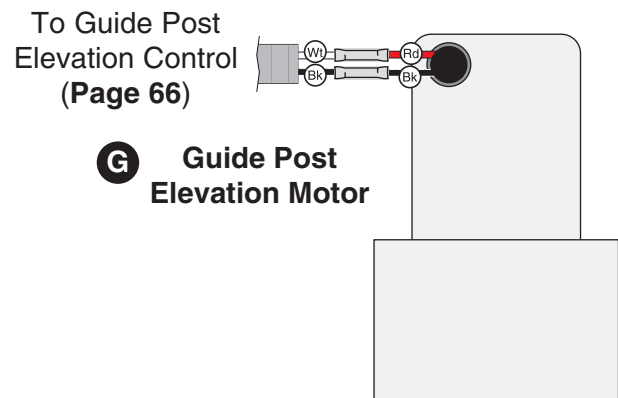
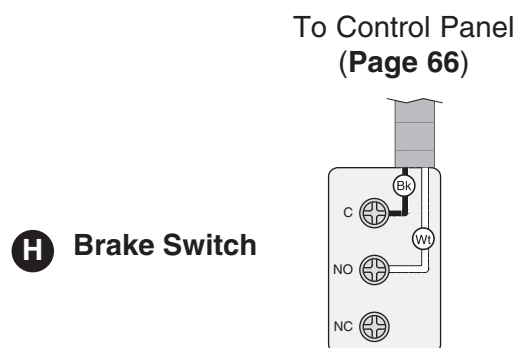
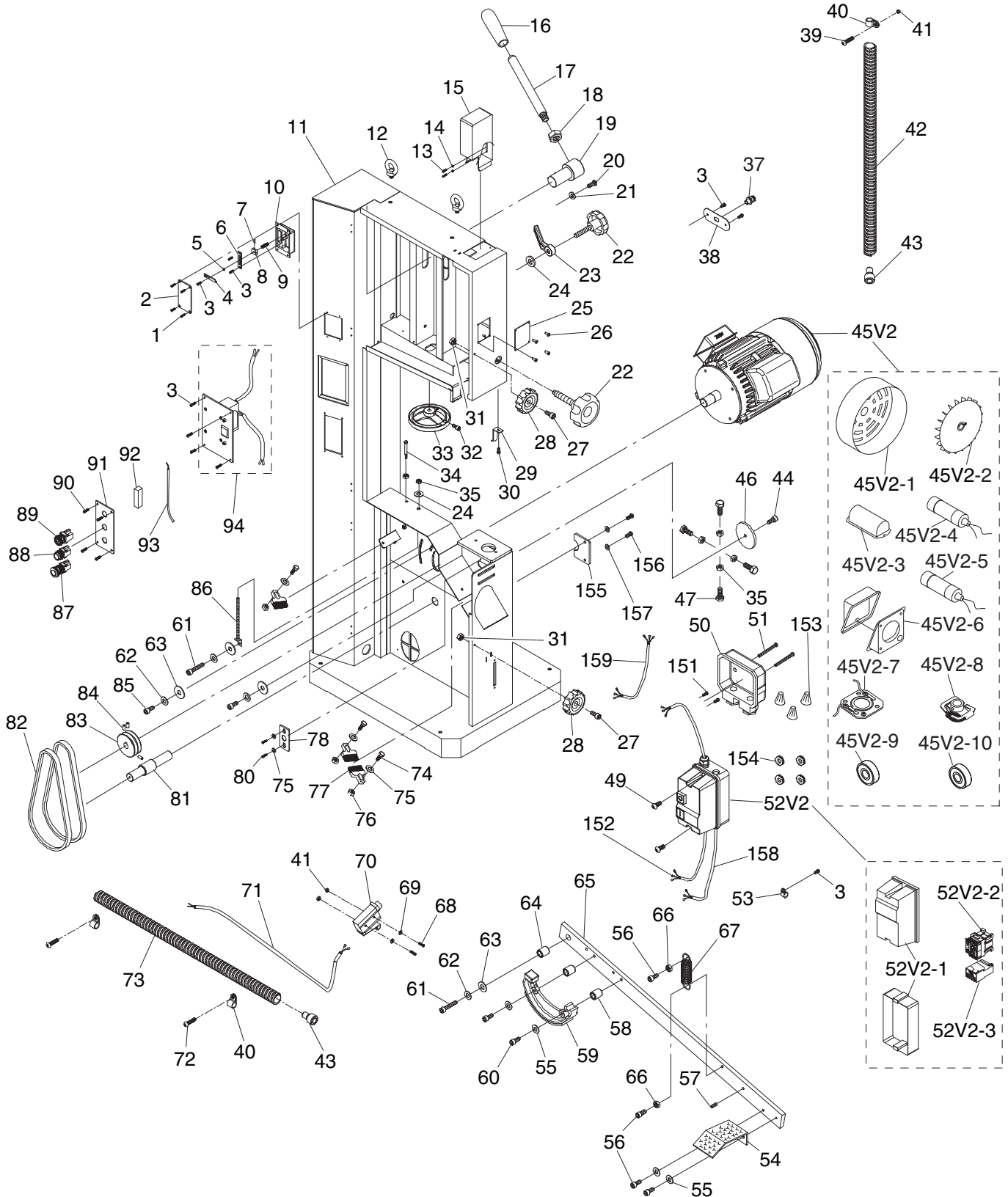


Figure 96. Brake switch wiring.



SECTION 9: PARTS

Frame



Frame Parts List

| REF | PART # | DESCRIPTION |
|------|------------|--------------------------------|
| 1 | PHTEK4M | TAP SCREW M4 X 8 |
| 2 | P0701002 | TENSION SCALE PLATE |
| 3 | PHTEK15M | TAP SCREW M4 X 10 |
| 4 | P0701004 | TENSION POINTER |
| 5 | PW05M | FLAT WASHER 4MM |
| 6 | P0701006 | TENSION SCALE BRACKET |
| 7 | PRP61M | ROLL PIN 3 X 12 |
| 8 | P0701008 | TENSION POINTER BRACKET |
| 9 | P0701009 | TORSION SPRING |
| 10 | P0701010 | TENSION SCALE BOX |
| 11 | P0701011 | FRAME |
| 12 | P0701012 | LIFTING EYE BOLT M12-1.75 X 20 |
| 13 | P0701013 | SHOULDER SCREW M4-.7 X 6 |
| 14 | P0701014 | FLAT WASHER 13 X 6 X 1.5 |
| 15 | P0701015 | GUIDE POST TOP CAP |
| 16 | P0636X001 | KNOB |
| 17 | P0636X002 | LEVER |
| 18 | PN13M | HEX NUT M16-2 |
| 19 | P0636X004 | LEVER HUB |
| 20 | PB56M | CAP SCREW M10-1.5 X 20 |
| 21 | PLW06M | LOCK WASHER 10MM |
| 22 | P0701022 | STAR KNOB BOLT M10-1.5 X 55 |
| 23 | P0636X008 | LEVER |
| 24 | PW04M | FLAT WASHER 10MM |
| 25 | P0636X067 | CLEAR PLASTIC WINDOW |
| 26 | P0636X068 | RIVET 3.2 X 10 |
| 27 | PCAP02M | CAP SCREW M6-1 X 20 |
| 28 | P0636X071 | STAR KNOB |
| 29 | P0636X072 | POINTER |
| 30 | PFS07M | FLANGE SCREW M5-.8 X 10 |
| 31 | PLN03M | LOCK NUT M6-1 |
| 32 | PCAP06M | CAP SCREW M6-1 X 25 |
| 33 | P0636X075 | HANDWHEEL |
| 34 | PB127M | HEX BOLT M10-1.5 X 110 |
| 35 | PN02M | HEX NUT M10-1.5 |
| 37 | P0636X107 | STRAIN RELIEF |
| 38 | P0636X108 | PLATE |
| 39 | PS56M | PHLP HD SCR M4-.7 X 16 |
| 40 | P0701040 | CORD CLAMP 5/8" |
| 41 | PN04M | HEX NUT M4-.7 |
| 42 | P0701042 | FLEXIBLE TUBE 1/2" X 43-1/2" |
| 43 | P0701043 | STRAIN RELIEF |
| 44 | PCAP31M | CAP SCREW M8-1.25 X 25 |
| 45V2 | P0701045V2 | MOTOR 5HP 230V 1PH V2.03.12 |

| REF | PART # | DESCRIPTION |
|---------|---------------|---------------------------------|
| 45V2-1 | P0701045V2-1 | MOTOR FAN COVER |
| 45V2-2 | P0701045V2-2 | MOTOR FAN |
| 45V2-3 | P0701045V2-3 | CAPACITOR COVER |
| 45V2-4 | P0701045V2-4 | S CAPACITOR 300M 250V |
| 45V2-5 | P0701045V2-5 | R CAPACITOR 45M 450V |
| 45V2-6 | P0701045V2-6 | MOTOR WIRING JUNCTION BOX |
| 45V2-7 | P0701045V2-7 | CONTACT PLATE |
| 45V2-8 | P0701045V2-8 | CENTRIFUGAL SWITCH 1720 |
| 45V2-9 | P6206-2RS | BALL BEARING 6206 2RS |
| 45V2-10 | P6204ZZ | BALL BEARING 6204ZZ |
| 46 | P0636X095 | WHEEL ADJUSTMENT BRACKET |
| 47 | PB14M | HEX BOLT M10-1.5 X 35 |
| 50 | P0636X100 | JUNCTION BOX |
| 51 | PFS09M | FLANGE SCREW M5-.8 X 50 |
| 52V2 | P0636X105V2 | MAG SWITCH ASSY MPE-30 V2.03.12 |
| 52V2-1 | P0636X105-1 | MAG SWITCH HOUSING |
| 52V2-2 | P0636X105-2 | CONTACTOR SDE MA-30 220V-240V |
| 52V2-3 | P0636X105-3V2 | OL RELAY SDE RA-30A 18-26A |
| 53 | P0701053 | CORD CLAMP 1/2" |
| 54 | P0636X084 | BRAKE PEDAL |
| 55 | PLW03M | LOCK WASHER 6MM |
| 56 | PCAP01M | CAP SCREW M6-1 X 16 |
| 57 | P0701057 | LOCKING SET SCREW M7-1 X 10 |
| 58 | P0636X079 | BUSHING |
| 59 | P0636X036 | BRAKE SHOE |
| 60 | PCAP06M | CAP SCREW M6-1 X 25 |
| 61 | PCAP13M | CAP SCREW M8-1.25 X 30 |
| 62 | PLW04M | LOCK WASHER 8MM |
| 63 | PW01M | FLAT WASHER 8MM |
| 64 | P0636X121 | BUSHING |
| 65 | P0701065 | BRAKE LEVER |
| 66 | PN01M | HEX NUT M6-1 |
| 67 | P0636X083 | EXTENSION SPRING |
| 68 | PS51M | PHLP HD SCR M4-.7 X 30 |
| 69 | PW05M | FLAT WASHER 4MM |
| 70 | P0636X086 | BRAKE SWITCH |
| 71 | P0636X090 | BRAKE SWITCH CORD |
| 72 | PHTEK4M | TAP SCREW M4 X 8 |
| 73 | P0636X092 | FLEXIBLE TUBE 1/2 X 44 IN |
| 74 | PB10M | HEX BOLT M6-1 X 25 |
| 75 | PW03M | FLAT WASHER 6MM |
| 76 | PLN03M | LOCK NUT M6-1 |
| 77 | P0636X093 | WHEEL BRUSH |
| 78 | P0636X076 | LOWER WHEEL SUPPORT |



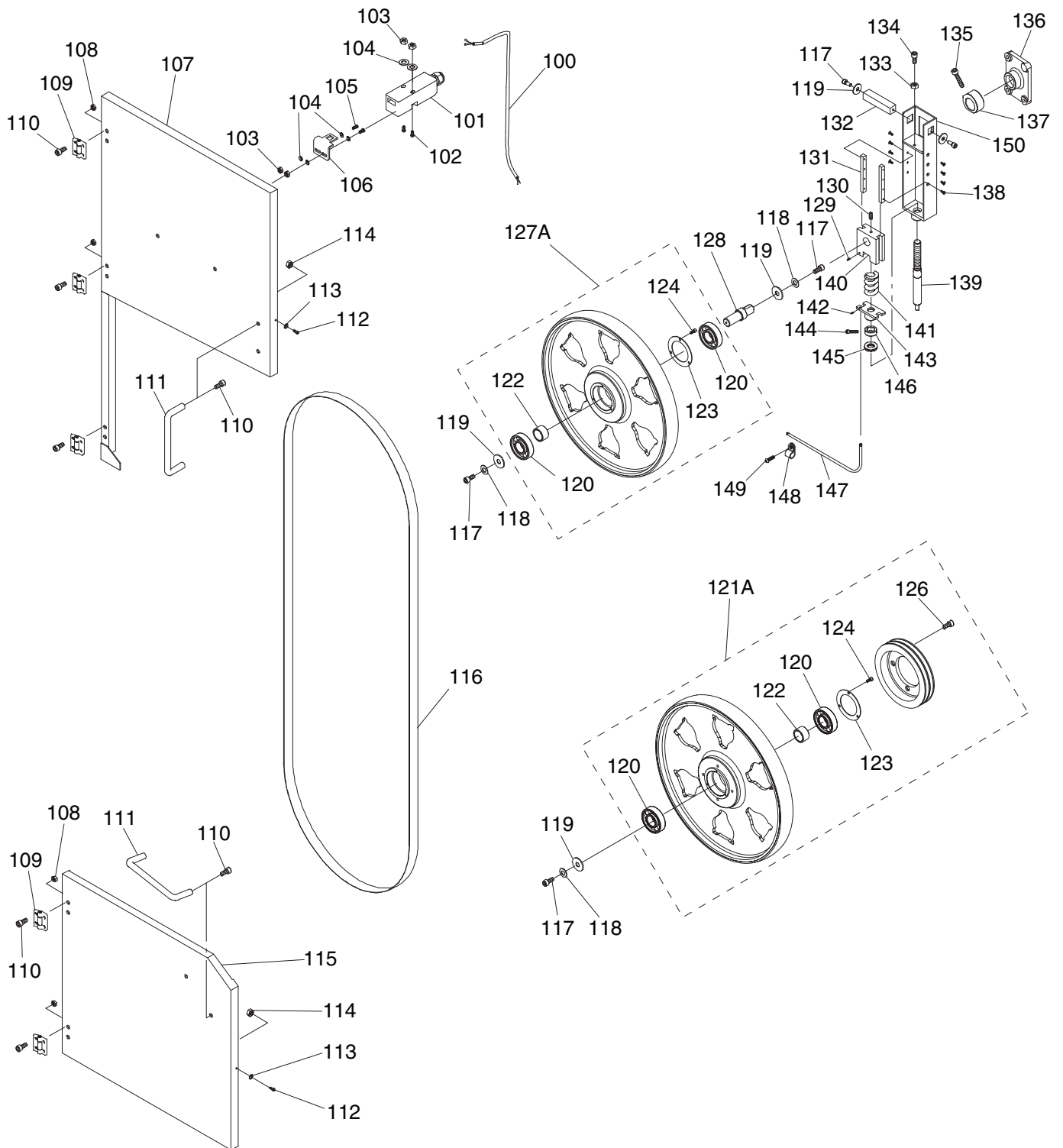
Frame Parts List (cont'd)

| REF | PART # | DESCRIPTION |
|-----|-----------|------------------------|
| 80 | PCAP01M | CAP SCREW M6-1 X 16 |
| 81 | P0636X062 | LOWER WHEEL SHAFT |
| 82 | PVA32 | V-BELT A32 |
| 83 | P0636X064 | MOTOR PULLEY |
| 84 | PSS04M | SET SCREW M6-1 X 12 |
| 85 | PCAP31M | CAP SCREW M8-1.25 X 25 |
| 86 | P0636X055 | BRUSH ADJUSTMENT STUD |
| 87 | P0636X048 | ON BUTTON |
| 88 | P0636X049 | OFF BUTTON |
| 89 | P0636X050 | KEYED POWER SWITCH |
| 90 | PS09M | PHLP HD SCR M5-.8 X 10 |
| 91 | P0636X051 | CONTROL PANEL |

| REF | PART # | DESCRIPTION |
|-----|-----------|-----------------------------|
| 92 | P0636X052 | CORD CONNECTOR |
| 93 | P0636X053 | CONTROL PANEL CORD |
| 94 | P0701094 | GUIDE POST ELEVATION SWITCH |
| 151 | PS38M | PHLP HD SCR M4-.7 X 10 |
| 152 | P0701152 | MOTOR CORD 12G 3W |
| 153 | P0701153 | WIRE NUT P3 |
| 154 | PTLW02M | EXT TOOTH WASHER 5MM |
| 155 | P0701155 | ADJUSTMENT PLATE |
| 156 | PB107M | HEX BOLT M5-.8 X 12 |
| 157 | PW02M | FLAT WASHER 5MM |
| 158 | P0701158 | CONTROL PANEL CORD 12G 4W |
| 159 | P0701159 | CONNECTING CORD 12G 3W |



Wheels



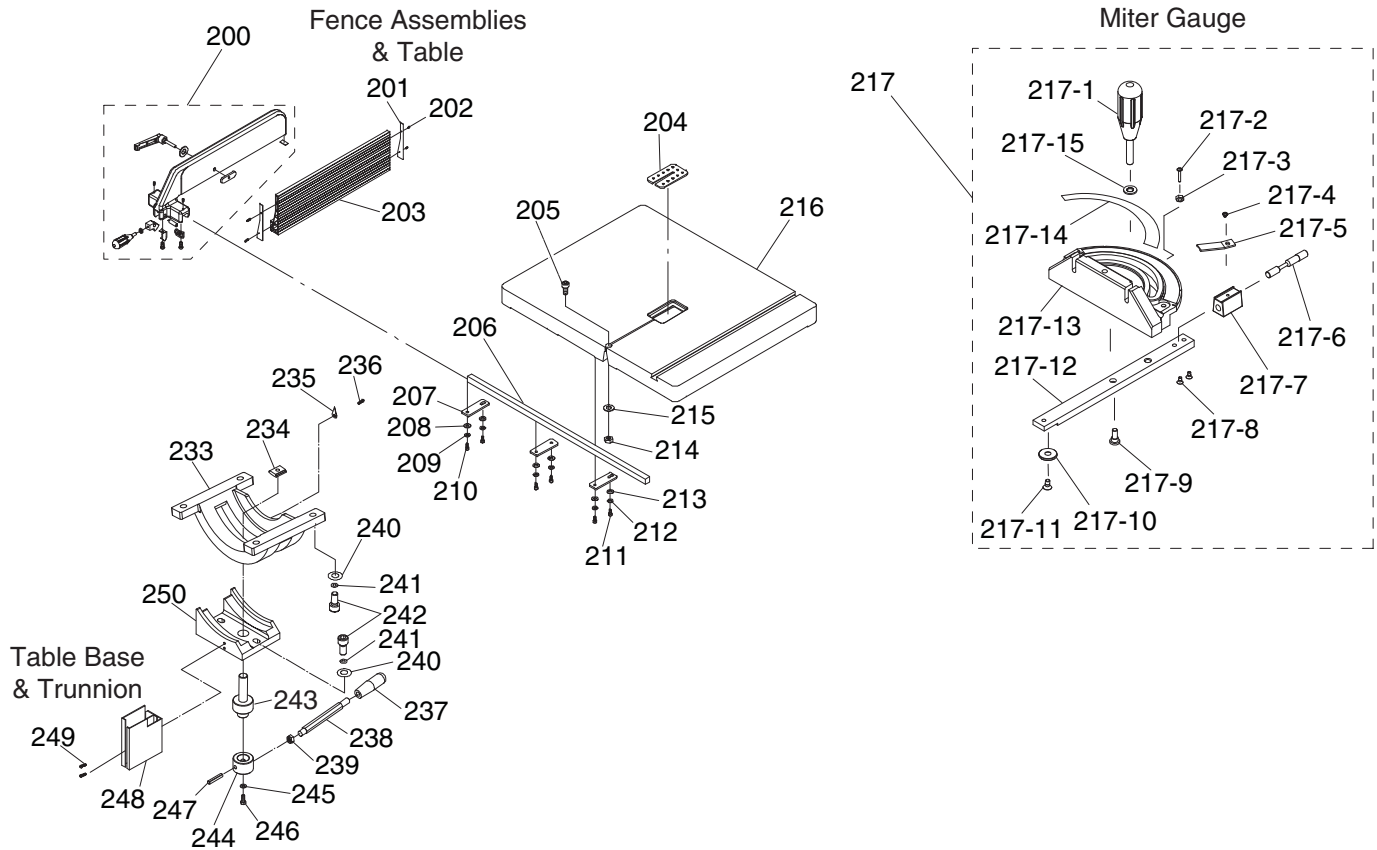
Wheels Parts List

| REF | PART # | DESCRIPTION |
|------|-----------|----------------------------------|
| 100 | P0701100 | DOOR SAFETY SWITCH CORD |
| 101 | P0636X111 | DOOR SAFETY SWITCH |
| 102 | PFS10M | FLANGE SCREW M4-.7 X 35 |
| 103 | PN04M | HEX NUT M4-.7 |
| 104 | PW05M | FLAT WASHER 4MM |
| 105 | PS38M | PHLP HD SCR M4-.7 X 10 |
| 106 | P0636X111 | DOOR SAFETY SWITCH BRACKET |
| 107 | P0701107 | UPPER WHEEL DOOR |
| 108 | PFN04M | FLANGE NUT M5-.8 |
| 109 | P0701109 | DOOR HINGE |
| 110 | PCAP33M | CAP SCREW M5-.8 X 12 |
| 111 | P0701111 | DOOR HANDLE |
| 112 | PCAP01M | CAP SCREW M6-1 X 16 |
| 113 | PLW03M | FLAT WASHER 13 X 6 X 1.5 |
| 114 | PLN03M | LOCK NUT M6-1 |
| 115 | P0701115 | LOWER WHEEL DOOR |
| 116 | P0701116 | SAW BLADE 166" X 1-3/8" X 0.035" |
| 117 | PCAP31M | CAP SCREW M8-1.25 X 25 |
| 118 | PLW03M | LOCK WASHER 6MM |
| 119 | P0636X018 | SHAFT FLAT WASHER 8MM |
| 120 | P6306-2RS | BALL BEARING 6306-2RS |
| 121A | P0701121A | LOWER WHEEL ASSEMBLY |
| 122 | P0701122 | BUSHING |
| 123 | P0701123 | BEARING END CAP |
| 124 | PS11M | PHLP HD SCR M6-1 X 16 |

| REF | PART # | DESCRIPTION |
|------|-----------|-------------------------|
| 126 | PCAP14M | CAP SCREW M8-1.25 X 20 |
| 127A | P0701127A | UPPER WHEEL ASSEMBLY |
| 128 | P0636X031 | UPPER WHEEL SHAFT |
| 129 | PSS07M | SET SCREW M5-.8 X 5 |
| 130 | PSS75M | SET SCREW M10-1.5 X 16 |
| 131 | P0636X021 | GIB |
| 132 | P0636X017 | SQUARE SHAFT |
| 133 | PN03M | HEX NUT M8-1.25 |
| 134 | PCAP05M | CAP SCREW M8-1.25 X 50 |
| 135 | PCAP13M | CAP SCREW M8-1.25 X 30 |
| 136 | P0636X011 | BRACKET |
| 137 | P0636X012 | CAM |
| 138 | PFH39M | FLAT HD SCR M5-.8 X 16 |
| 139 | P0701139 | TENSION ADJUSTMENT BOLT |
| 140 | P0636X023 | GUIDE BLOCK |
| 141 | P0636X025 | COMPRESSION SPRING |
| 142 | PSS79M | SET SCREW M4-.7 X 6 |
| 143 | P0701143 | SPRING PLATE |
| 144 | PCAP12M | CAP SCREW M8-1.25 X 40 |
| 145 | P0701145 | BEARING END CAP |
| 146 | P51105 | THRUST BEARING 51105 |
| 147 | P0701147 | TENSION CABLE |
| 148 | P0701148 | CORD CLAMP 5/16" |
| 149 | PHTEK15M | TAP SCREW M4 X 10 |
| 150 | P0636X016 | UPPER WHEEL HINGE |



Table Parts & List

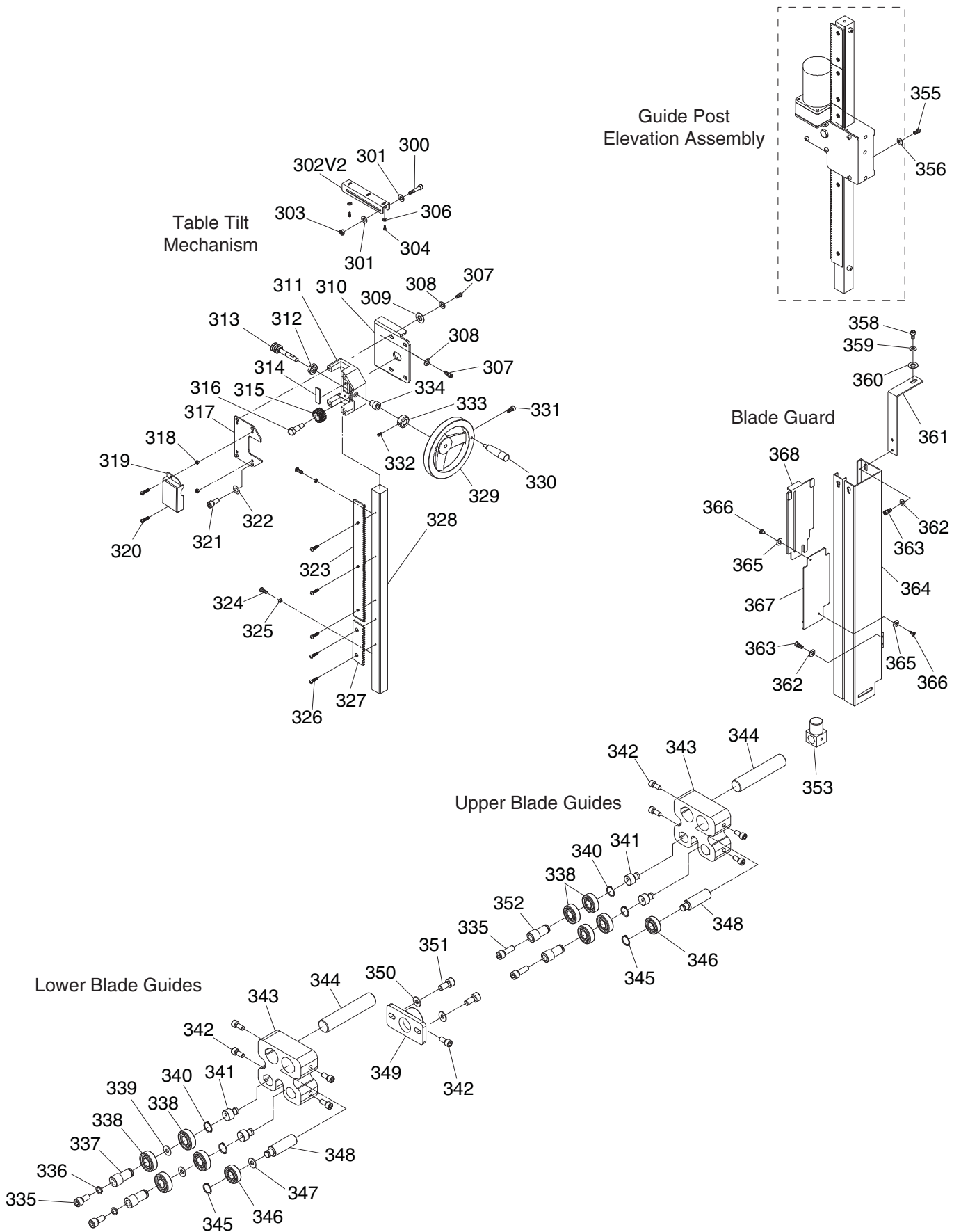


| REF | PART # | DESCRIPTION |
|-------|-------------|--------------------------|
| 200 | P0701200 | FENCE ASSEMBLY |
| 201 | P0636X123 | END CAP |
| 202 | PHTEK15M | TAP SCREW M4 X 10 |
| 203 | P0701203 | RESAW FENCE ALUMINUM |
| 204 | P0636X161 | TABLE INSERT |
| 205 | PCAP05M | CAP SCREW M8-1.25 X 50 |
| 206 | P0701206 | FENCE RAIL |
| 207 | P0701207 | FENCE RAIL PLATE |
| 208 | PW03M | FLAT WASHER 6MM |
| 209 | PLW03M | LOCK WASHER 6MM |
| 210 | PB08M | HEX BOLT M6-1 X 20 |
| 211 | PB09M | HEX BOLT M8-1.25 X 20 |
| 212 | PLW04M | LOCK WASHER 8MM |
| 213 | PW01M | FLAT WASHER 13 X 6 X 1.5 |
| 214 | PN03M | HEX NUT M8-1.25 |
| 215 | PW01M | FLAT WASHER 8MM |
| 216 | P0701216 | TABLE |
| 217 | P0636X160 | MITER GAUGE ASSEMBLY |
| 217-1 | P0636X160-7 | MITER HANDLE |
| 217-2 | PS56M | PHLP HD SCR M4-.7 X 16 |
| 217-3 | PN04M | HEX NUT M4-.7 |
| 217-4 | PS18 | PHLP HD SCR 10-24 X 1/4 |
| 217-5 | P0636X160-5 | POINTER |
| 217-6 | P0636X160-4 | INDEX SHAFT |
| 217-7 | P0636X160-3 | INDEX SHAFT BRACKET |
| 217-8 | PS18 | PHLP HD SCR 10-24 X 1/4 |
| 233 | P0636X157 | TABLE BASE |
| 234 | P0636X158 | TRUNNION T-NUT |
| 235 | P0636X155 | POINTER |
| 236 | PS38M | PHLP HD SCR M4-.7 X 10 |
| 237 | P0636X153 | TRUNNION HANDLE M12-1.75 |
| 238 | P0636X152 | HANDLE SHAFT |
| 239 | PN09M | HEX NUT M12-1.75 |
| 240 | PW04M | FLAT WASHER 10MM |
| 241 | PLW06M | LOCK WASHER 10MM |
| 242 | PCAP84M | CAP SCREW M10-1.5 X 35 |
| 243 | P0636X150 | PIVOT SHAFT |
| 244 | P0636X149 | LOCK COLLAR |
| 245 | PLW04M | LOCK WASHER 8MM |
| 246 | PB09M | HEX BOLT M8-1.25 X 20 |
| 247 | PRP31M | ROLL PIN 6 X 36 |
| 248 | P0636X146 | LOWER BLADE GUARD |
| 249 | PFB09M | FLANGE BOLT M6-1 X 10 |
| 250 | P0636X154 | TRUNNION |

| REF | PART # | DESCRIPTION |
|--------|-------------|--------------------------|
| 217-9 | P0636X160-6 | SHOULDER SCREW |
| 217-10 | P0701217-10 | SLOT WASHER |
| 217-11 | PFH04M | FLAT HD SCR M6-1 X 8 |
| 217-12 | P0636X160-2 | GUIDE BAR |
| 217-13 | P0636X160-8 | MITER GAUGE BODY |
| 217-14 | P0701217-14 | MITER SCALE |
| 217-15 | PW01M | FLAT WASHER 8MM |
| 233 | P0636X157 | TABLE BASE |
| 234 | P0636X158 | TRUNNION T-NUT |
| 235 | P0636X155 | POINTER |
| 236 | PS38M | PHLP HD SCR M4-.7 X 10 |
| 237 | P0636X153 | TRUNNION HANDLE M12-1.75 |
| 238 | P0636X152 | HANDLE SHAFT |
| 239 | PN09M | HEX NUT M12-1.75 |
| 240 | PW04M | FLAT WASHER 10MM |
| 241 | PLW06M | LOCK WASHER 10MM |
| 242 | PCAP84M | CAP SCREW M10-1.5 X 35 |
| 243 | P0636X150 | PIVOT SHAFT |
| 244 | P0636X149 | LOCK COLLAR |
| 245 | PLW04M | LOCK WASHER 8MM |
| 246 | PB09M | HEX BOLT M8-1.25 X 20 |
| 247 | PRP31M | ROLL PIN 6 X 36 |
| 248 | P0636X146 | LOWER BLADE GUARD |
| 249 | PFB09M | FLANGE BOLT M6-1 X 10 |
| 250 | P0636X154 | TRUNNION |



Guides



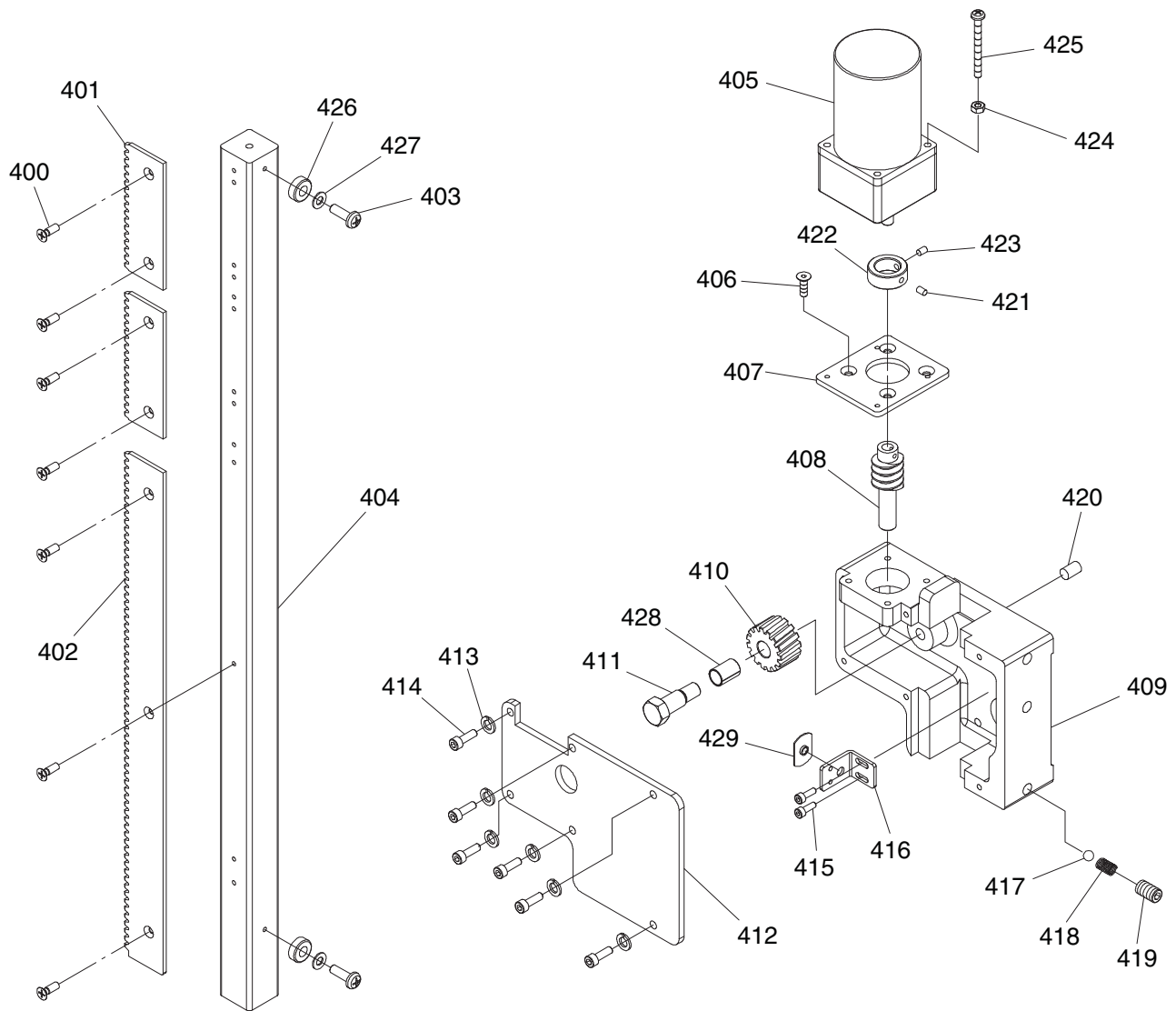
Guides Parts List

| REF | PART # | DESCRIPTION |
|-------|-------------|--------------------------------|
| 300 | PB30M | HEX BOLT M8-1.25 X 55 |
| 301 | PW01M | FLAT WASHER 8MM |
| 302V2 | P0636X233V2 | SLIDING BRACKET 300MM V2.11.11 |
| 303 | PLN04M | LOCK NUT M8-1.25 |
| 304 | PCAP04M | CAP SCREW M6-1 X 10 |
| 306 | PW03M | FLAT WASHER 6MM |
| 307 | PCAP31M | CAP SCREW M8-1.25 X 25 |
| 308 | PLW04M | LOCK WASHER 8MM |
| 309 | PW01M | FLAT WASHER 8MM |
| 310 | P0701310 | SUPPORT BRACKET |
| 311 | P0636X199 | GUIDE BRACKET |
| 312 | PN05M | HEX NUT M16-1.5 |
| 313 | P0636X201 | WORM SHAFT |
| 314 | P0636X203 | FLAT WASHER 13 X 6 X 1.5 |
| 315 | P0636X202 | PINION GEAR |
| 316 | P0636X204 | SHOULDER BOLT |
| 317 | P0636X205 | PROTECTIVE PLATE |
| 318 | PN06M | HEX NUT M5-.8 |
| 319 | P0636X209 | PROTECTIVE COVER |
| 320 | PFB08M | FLANGE BOLT M5-.8 X 10 |
| 321 | PCAP11M | CAP SCREW M8-1.25 X 16 |
| 322 | PLW04M | LOCK WASHER 8MM |
| 323 | P0636X212 | RACK |
| 324 | PS38M | PHLP HD SCR M4-.7 X 10 |
| 325 | PN04M | HEX NUT M4-.7 |
| 326 | PFH19M | FLAT HD SCR M4-.7 X 10 |
| 327 | P0636X213 | RACK EXTENSION |
| 328 | P0636X214 | TILT GUIDE POST |
| 329 | P0636X192 | HANDWHEEL |
| 330 | P0636X190 | HANDWHEEL HANDLE 3/8-16 X 1/2 |
| 331 | PCAP06M | CAP SCREW M6-1 X 25 |
| 332 | PSS07M | SET SCREW M5-.8 X 5 |
| 333 | P0636X193 | LOCK COLLAR |

| REF | PART # | DESCRIPTION |
|-----|-----------|----------------------------------|
| 334 | P0636X334 | BUSHING |
| 335 | PCAP29M | CAP SCREW M6-1 X 40 |
| 336 | PLW03M | LOCK WASHER 6MM |
| 337 | P0636X245 | STEPPED BUSHING |
| 338 | P6202ZZ | BALL BEARING 6202ZZ |
| 339 | P0701339 | SPACER |
| 340 | PR05M | EXT RETAINING RING 15MM |
| 341 | P0636X242 | ECCENTRIC BUSHING |
| 342 | PCAP01M | CAP SCREW M6-1 X 16 |
| 343 | P0636X240 | GUIDE BLOCK |
| 344 | P0636X239 | BLADE GUIDE SHAFT |
| 345 | PR03M | EXT RETAINING RING 12MM |
| 346 | P6201ZZ | BALL BEARING 6201ZZ |
| 347 | P0701347 | SPACER |
| 348 | P0636X249 | STEPPED BUSHING |
| 349 | P0636X238 | LOWER GUIDE BLOCK BRACKET |
| 350 | PW03M | FLAT WASHER 6MM |
| 351 | PCAP01M | CAP SCREW M6-1 X 16 |
| 352 | P0636X245 | STEPPED BUSHING |
| 353 | P0701353 | UPPER GUIDE BLOCK BRACKET |
| 355 | PCAP40M | CAP SCREW M8-1.25 X 35 |
| 356 | PW01M | FLAT WASHER 8MM |
| 358 | PCAP01M | CAP SCREW M6-1 X 16 |
| 359 | PLW03M | LOCK WASHER 6MM |
| 360 | PW03M | FLAT WASHER 6MM |
| 361 | P0701361 | SUPPORT BRACKET |
| 362 | PW03M | FLAT WASHER 6MM |
| 363 | PCAP04M | CAP SCREW M6-1 X 10 |
| 364 | P0701364 | UPPER BLADE GUARD |
| 365 | P0701014 | PLASTIC FLAT WASHER 13 X 6 X 1.5 |
| 366 | P0701013 | SHOULDER SCREW M4-.7 X 6 |
| 367 | P0701367 | BLADE GUARD COVER EXTERNAL |



Guide Post Elevation Assembly

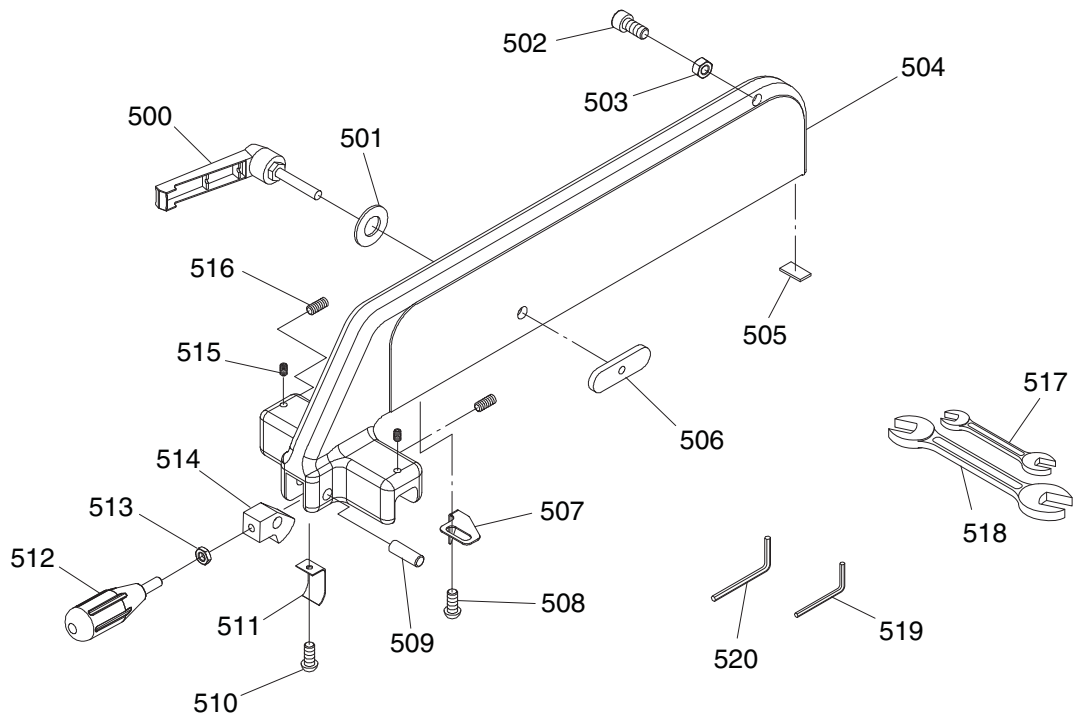


| REF | PART # | DESCRIPTION |
|-----|----------|----------------------------|
| 400 | PFH25M | FLAT HD SCR M4-.7 X 12 |
| 401 | P0701401 | RACK EXTENSION |
| 402 | P0701402 | RACK |
| 403 | PFS14M | FLANGE SCREW M6-1 X 16 |
| 404 | P0701404 | UPPER GUIDE POST |
| 405 | P0701405 | GUIDE POST MOTOR 40W 12VDC |
| 406 | PFH39M | FLAT HD SCR M5-.8 X 16 |
| 407 | P0701407 | MOTOR MOUNT |
| 408 | P0701408 | WORM SHAFT |
| 409 | P0701409 | ELEVATION GEAR HOUSING |
| 410 | P0701410 | PINION GEAR |
| 411 | P0701411 | SHOULDER BOLT |
| 412 | P0701412 | GEAR HOUSING COVER |
| 413 | PLW01M | FLAT WASHER 13 X 6 X 1.5 |
| 414 | PCAP24M | CAP SCREW M5-.8 X 16 |

| REF | PART # | DESCRIPTION |
|-----|----------|---------------------------|
| 415 | PS07M | PHLP HD SCR M4-.7 X 8 |
| 416 | P0701416 | BRACKET |
| 417 | P0701417 | STEEL BALL |
| 418 | P0701418 | COMPRESSION SPRING |
| 419 | PSS30M | SET SCREW M10-1.5 X 10 |
| 420 | P0701420 | NYLON SET SCREW M7-1 X 10 |
| 421 | PSS51M | SET SCREW M4-.7 X 8 |
| 422 | P0701422 | LOCK COLLAR |
| 423 | PSS79M | SET SCREW M4-.7 X 6 |
| 424 | PN06M | HEX NUT M5-.8 |
| 425 | PS104M | PHLP HD SCR M5-.8 X 55 |
| 426 | P0701426 | RUBBER SPACER 6MM |
| 427 | PW03M | FLAT WASHER 6MM |
| 428 | P0701428 | GEAR BUSHING |
| 429 | P0701429 | NYLON INSERT |



Fence Assembly & Tools

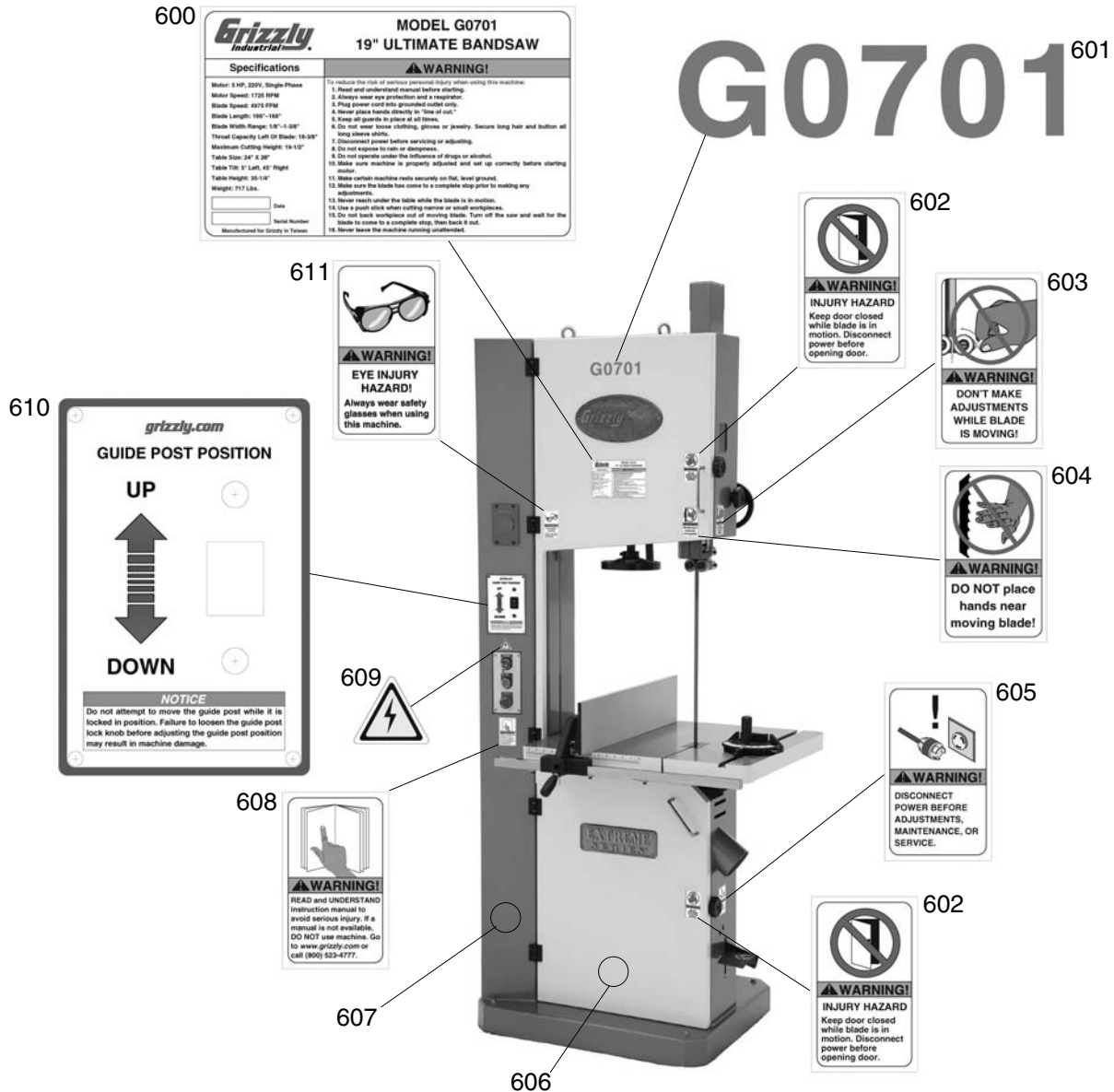


| REF | PART # | DESCRIPTION |
|-----|-----------|-------------------------|
| 500 | P0636X129 | LOCK LEVER M8-1.25 X 45 |
| 501 | PW01M | FLAT WASHER 8MM |
| 502 | PCAP14M | CAP SCREW M8-1.25 X 20 |
| 503 | PN03M | HEX NUT M8-1.25 |
| 504 | P0636X125 | FENCE |
| 505 | P0636X163 | NYLON PAD |
| 506 | P0636X126 | RESAW FENCE T-BAR |
| 507 | P0636X135 | POINTER |
| 508 | PFS01M | FLANGE SCREW M5-.8 X 8 |
| 509 | P0636X162 | SHAFT |
| 510 | PFS17M | FLANGE SCREW M4-.7 X 8 |

| REF | PART # | DESCRIPTION |
|-----|-----------|---------------------------|
| 511 | P0636X133 | SPRING PLATE |
| 512 | P0636X132 | FENCE HANDLE M8-1.25 X 20 |
| 513 | PN03M | HEX NUT M8-1.25 |
| 514 | P0636X130 | LOCKING CLAMP |
| 515 | P0636X127 | SET SCREW NYLON M6-1 X 10 |
| 516 | PSS14M | SET SCREW M8-1.25 X 12 |
| 517 | PWR1013 | WRENCH 10/13MM |
| 518 | PWR1719 | WRENCH 17/19MM |
| 519 | PAW05M | HEX WRENCH 5MM |
| 520 | PAW06M | HEX WRENCH 6MM |



Machine Labels



| REF | PART # | DESCRIPTION |
|-----|------------|---------------------------|
| 600 | P0701600 | MACHINE ID LABEL |
| 601 | P0701601 | MODEL NUMBER LABEL |
| 602 | PLABEL-20 | DOOR HAZARD LABEL |
| 603 | PLABEL-21 | ADJUSTMENT HAZARD LABEL |
| 604 | PLABEL-19A | MOVING BLADE HAZARD LABEL |
| 605 | PLABEL-63 | DISCONNECT POWER LABEL |

| REF | PART # | DESCRIPTION |
|-----|------------|------------------------------|
| 606 | PPAINT-11 | GRIZZLY PUTTY TOUCH-UP PAINT |
| 607 | PPAINT-1 | GRIZZLY GREEN TOUCH-UP PAINT |
| 608 | PLABEL-12A | READ MANUAL LABEL |
| 609 | PLABEL-14 | ELECTRICITY LABEL |
| 610 | P0701610 | GUIDE POST ELEVATION LABEL |
| 611 | PLABEL-11A | EYE INJURY HAZARD LABEL |

⚠️ WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine **MUST** maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, **REPLACE** that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.





WARRANTY CARD

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The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. **Of course, all information is strictly confidential.**

1. How did you learn about us?

| | | |
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| <input type="checkbox"/> Advertisement | <input type="checkbox"/> Friend | <input type="checkbox"/> Catalog |
| <input type="checkbox"/> Card Deck | <input type="checkbox"/> Website | <input type="checkbox"/> Other: _____ |

2. Which of the following magazines do you subscribe to?

| | | |
|---|--|---|
| <input type="checkbox"/> Cabinetmaker & FDM | <input type="checkbox"/> Popular Science | <input type="checkbox"/> Wooden Boat |
| <input type="checkbox"/> Family Handyman | <input type="checkbox"/> Popular Woodworking | <input type="checkbox"/> Woodshop News |
| <input type="checkbox"/> Hand Loader | <input type="checkbox"/> Precision Shooter | <input type="checkbox"/> Woodsmith |
| <input type="checkbox"/> Handy | <input type="checkbox"/> Projects in Metal | <input type="checkbox"/> Woodwork |
| <input type="checkbox"/> Home Shop Machinist | <input type="checkbox"/> RC Modeler | <input type="checkbox"/> Woodworker West |
| <input type="checkbox"/> Journal of Light Cont. | <input type="checkbox"/> Rifle | <input type="checkbox"/> Woodworker's Journal |
| <input type="checkbox"/> Live Steam | <input type="checkbox"/> Shop Notes | <input type="checkbox"/> Other: _____ |
| <input type="checkbox"/> Model Airplane News | <input type="checkbox"/> Shotgun News | |
| <input type="checkbox"/> Old House Journal | <input type="checkbox"/> Today's Homeowner | |
| <input type="checkbox"/> Popular Mechanics | <input type="checkbox"/> Wood | |

3. What is your annual household income?

| | | |
|--|--|--|
| <input type="checkbox"/> \$20,000-\$29,000 | <input type="checkbox"/> \$30,000-\$39,000 | <input type="checkbox"/> \$40,000-\$49,000 |
| <input type="checkbox"/> \$50,000-\$59,000 | <input type="checkbox"/> \$60,000-\$69,000 | <input type="checkbox"/> \$70,000+ |

4. What is your age group?

| | | |
|--------------------------------|--------------------------------|--------------------------------|
| <input type="checkbox"/> 20-29 | <input type="checkbox"/> 30-39 | <input type="checkbox"/> 40-49 |
| <input type="checkbox"/> 50-59 | <input type="checkbox"/> 60-69 | <input type="checkbox"/> 70+ |

5. How long have you been a woodworker/metalworker?

| | | | |
|------------------------------------|------------------------------------|-------------------------------------|------------------------------------|
| <input type="checkbox"/> 0-2 Years | <input type="checkbox"/> 2-8 Years | <input type="checkbox"/> 8-20 Years | <input type="checkbox"/> 20+ Years |
|------------------------------------|------------------------------------|-------------------------------------|------------------------------------|

6. How many of your machines or tools are Grizzly?

| | | | |
|------------------------------|------------------------------|------------------------------|------------------------------|
| <input type="checkbox"/> 0-2 | <input type="checkbox"/> 3-5 | <input type="checkbox"/> 6-9 | <input type="checkbox"/> 10+ |
|------------------------------|------------------------------|------------------------------|------------------------------|

7. Do you think your machine represents a good value? Yes No

8. Would you recommend Grizzly Industrial to a friend? Yes No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: We never use names more than 3 times. Yes No

10. Comments: _____

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We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

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